SALUS SAUNAS

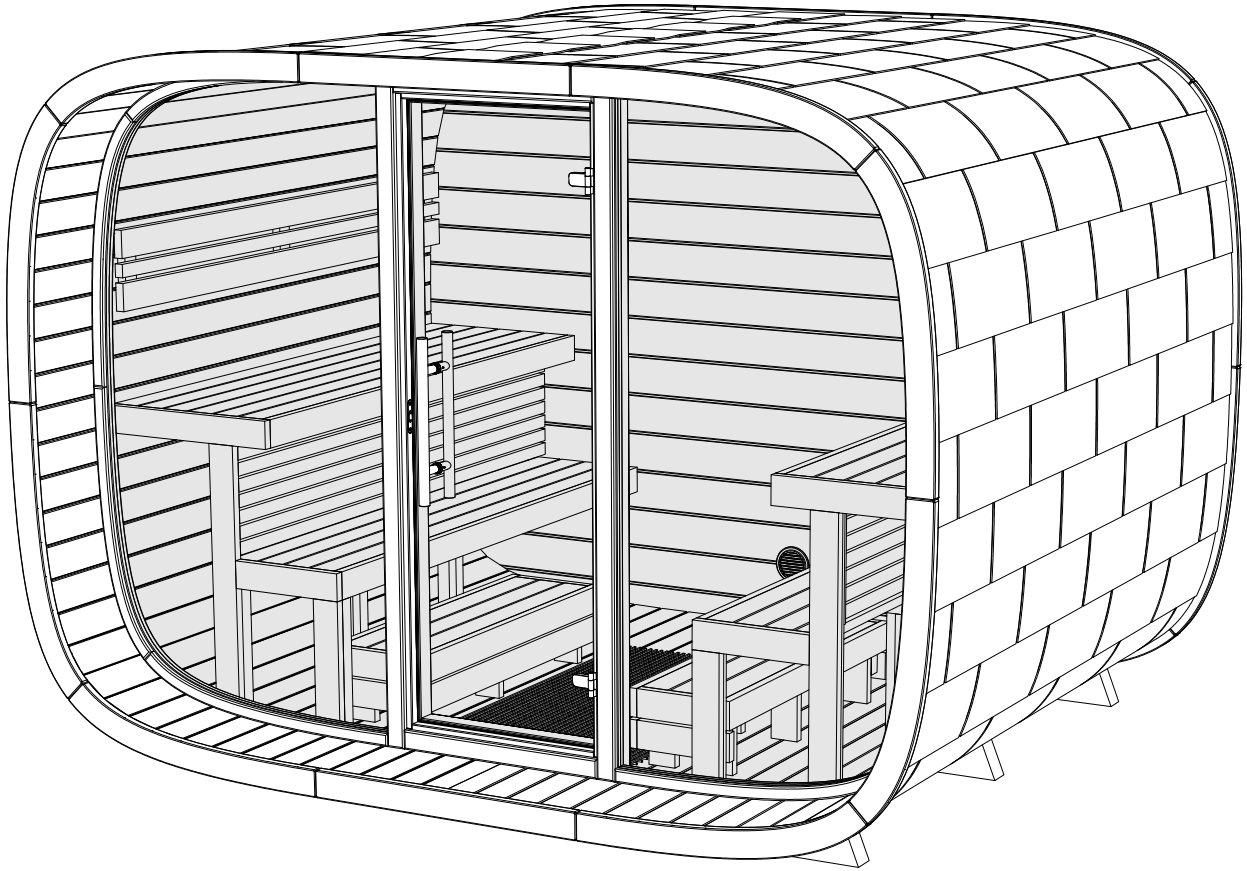
Vienna Single Sauna

OWNER'S MANUAL

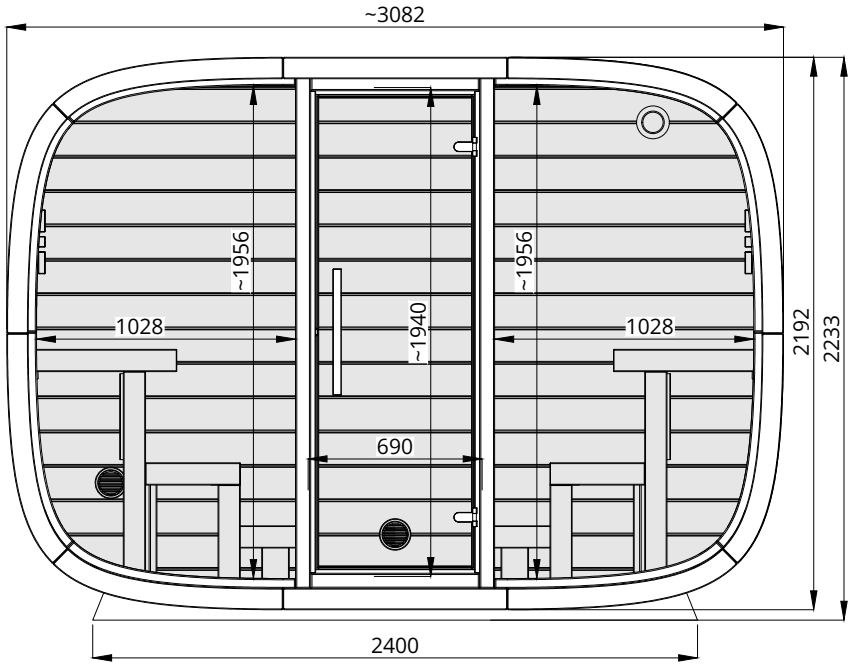
Carefully and thoroughly read this Owner's Manual before using/operating the sauna. We recommend keeping this Owner's Manual for regular review and future reference.nches.

Round Cube SINGLE 2.4 / 2.6

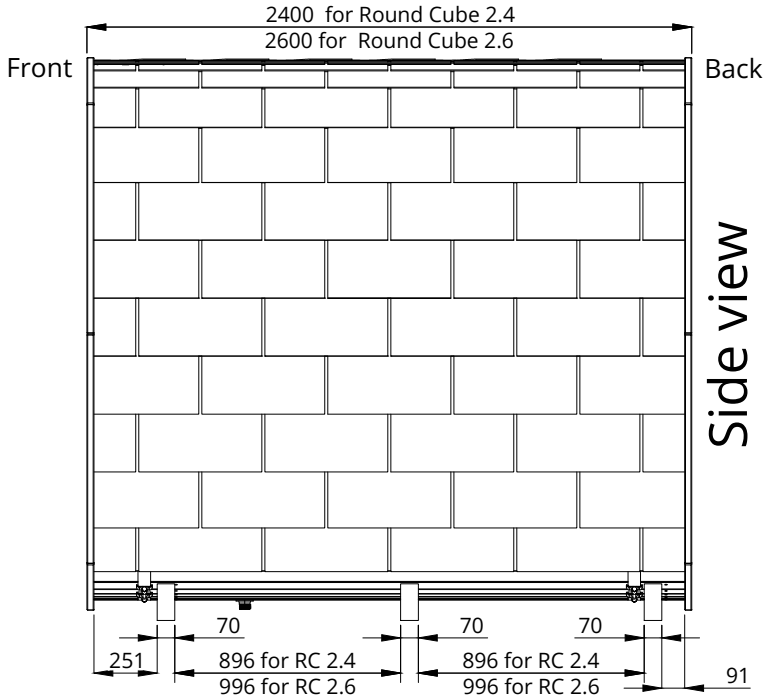
Construction guide

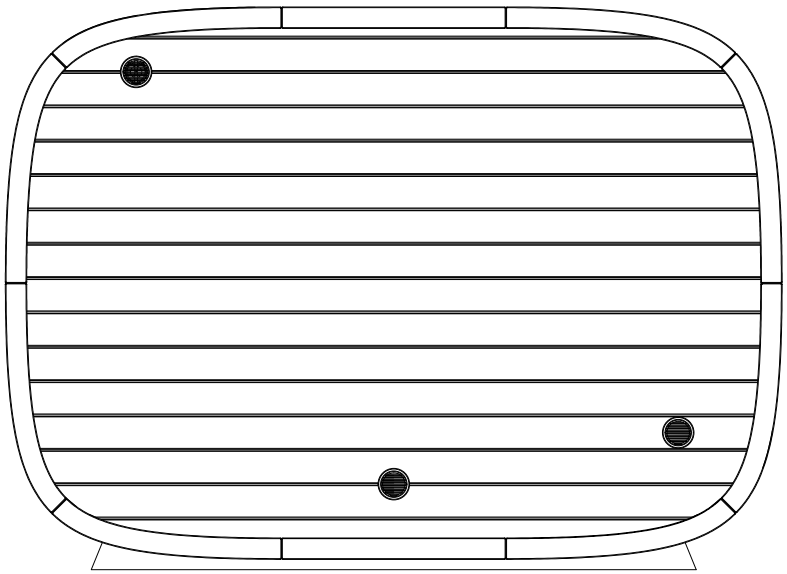


Check the parts for completeness before assembly!



Front view

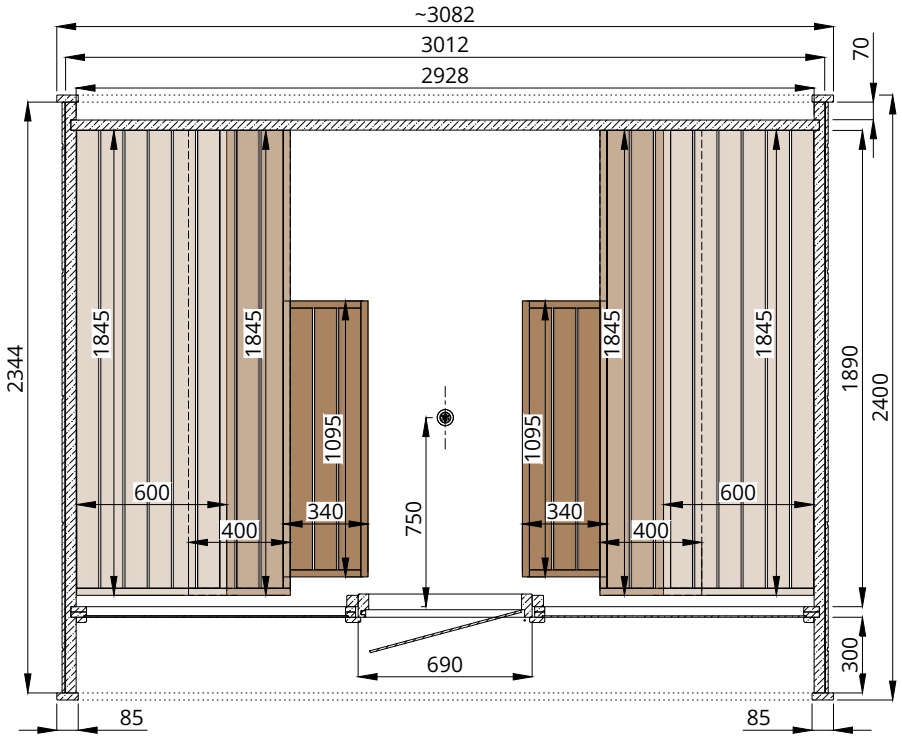


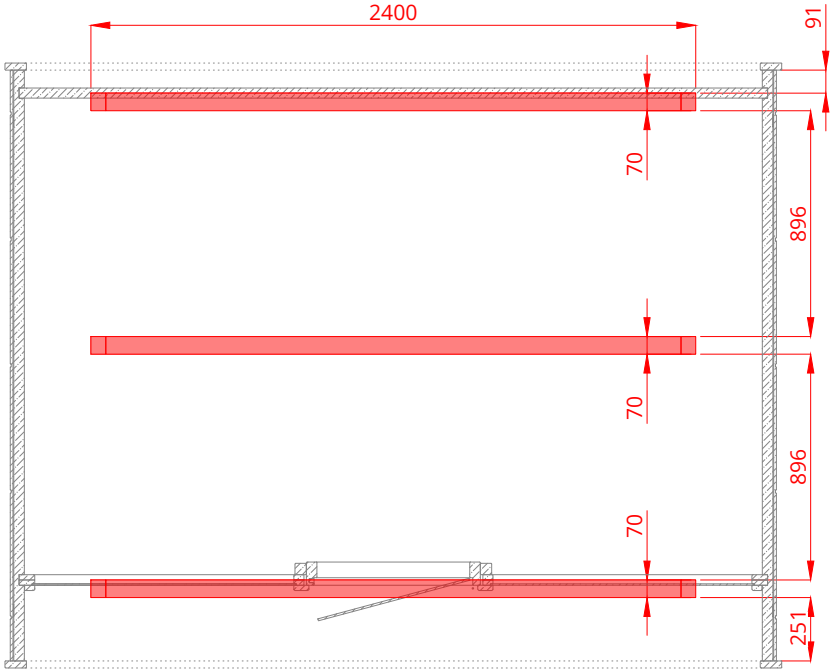


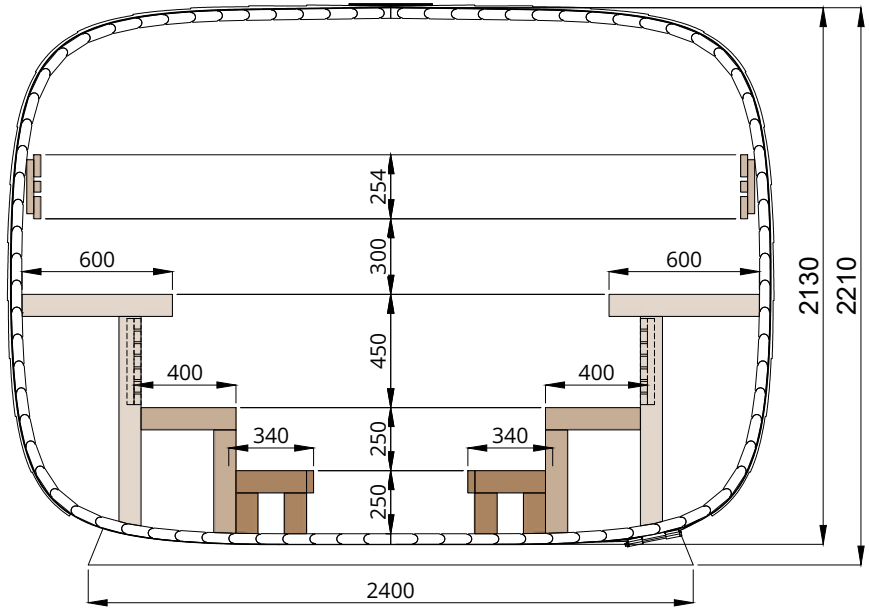
Back view

Scale 1 : 30

Round Cube

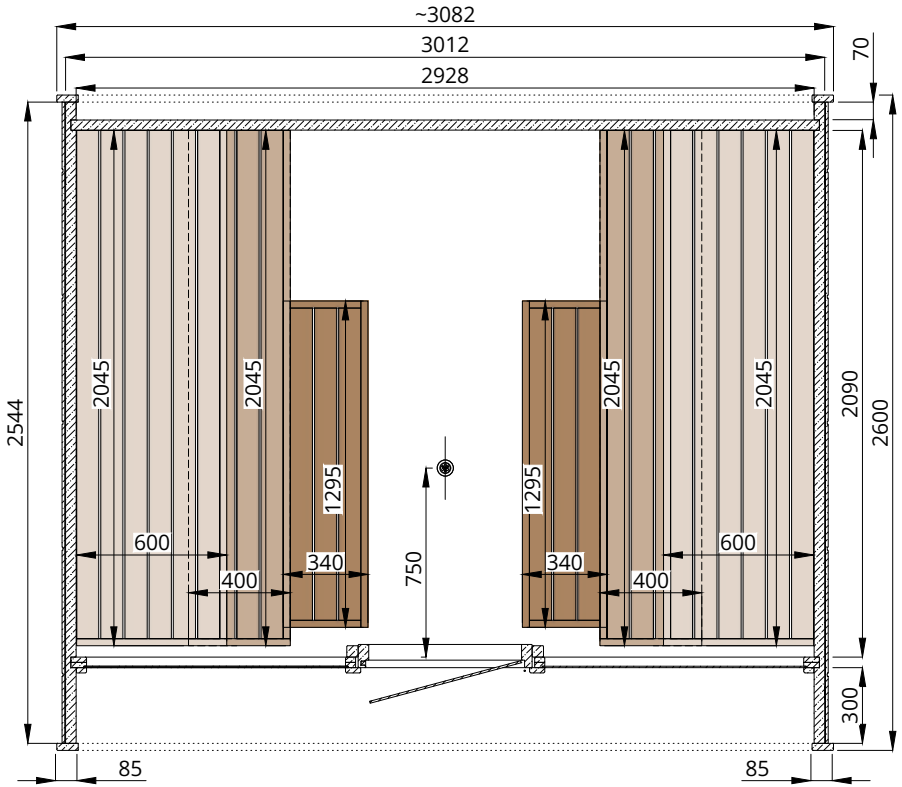


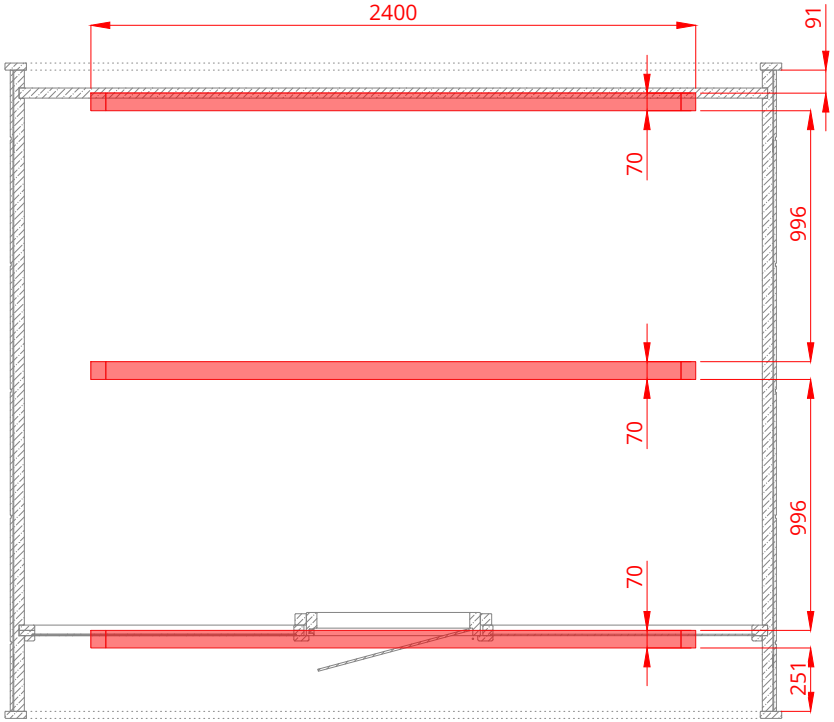


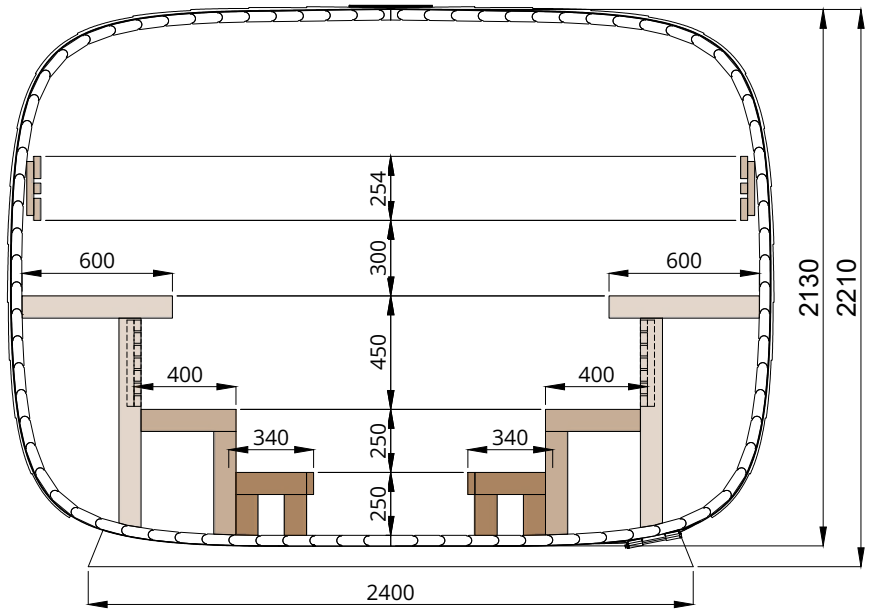


Scale 1 : 30

Round Cube 2.4

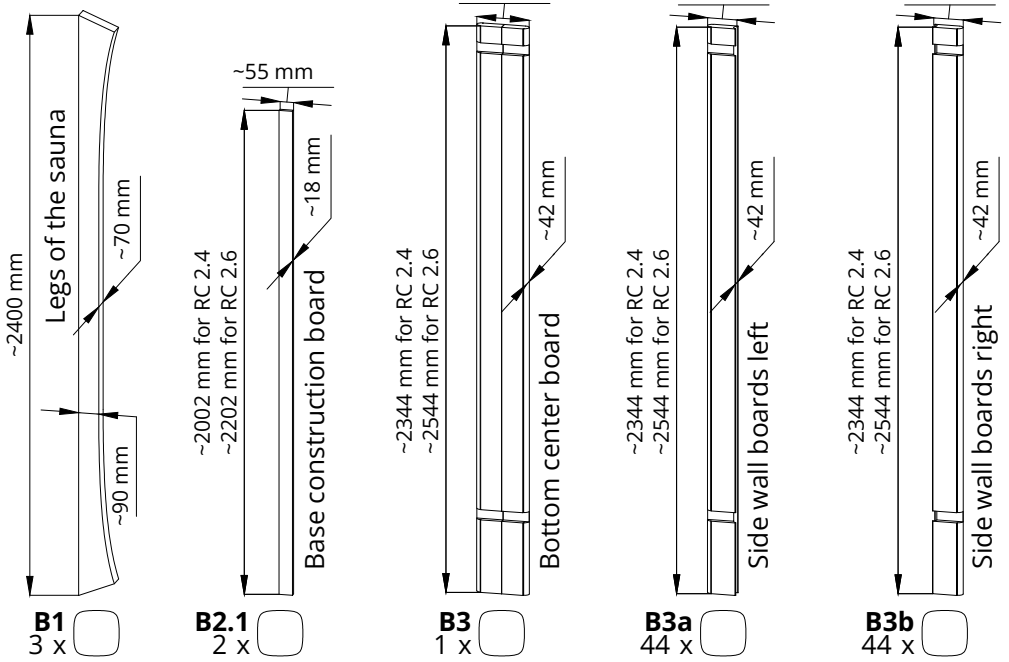


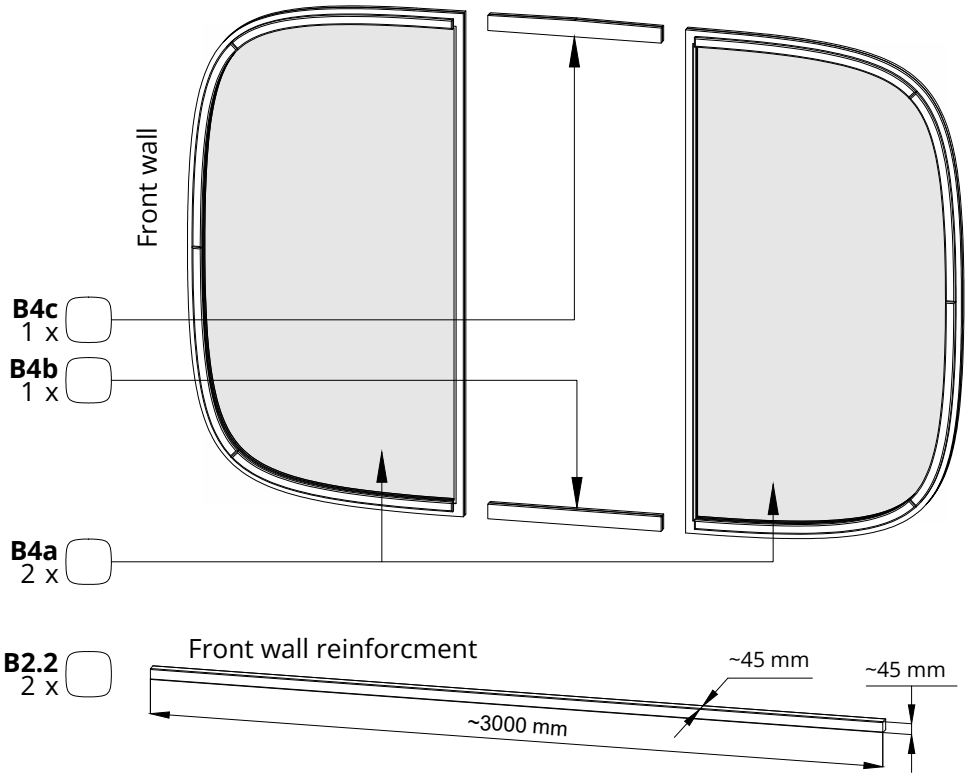


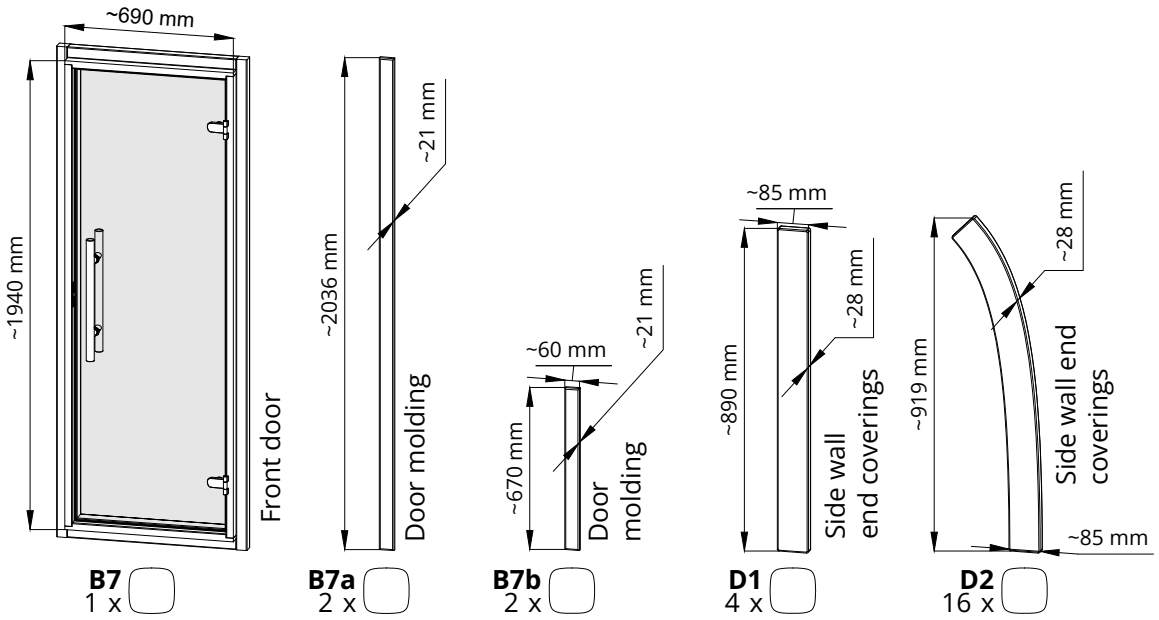


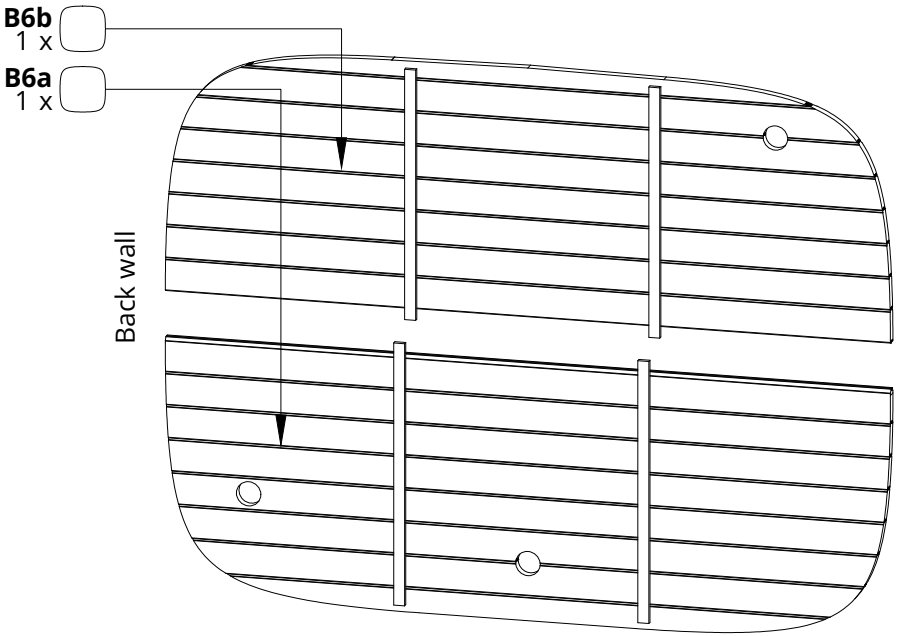
Scale 1 : 30

Round Cube 2.6

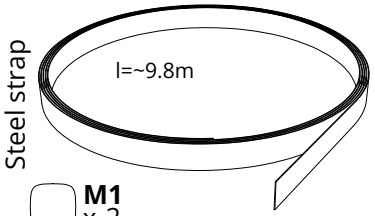




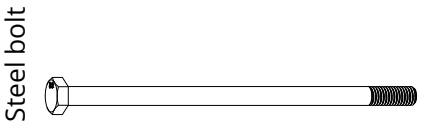




Detail list 1



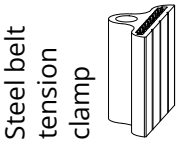
M1
x 2



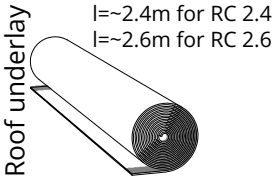
M2
x 2

M3
x 4

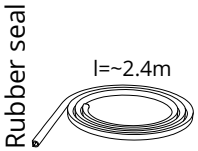
M4
x 2



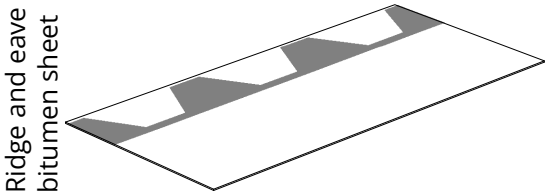
M5
x 4



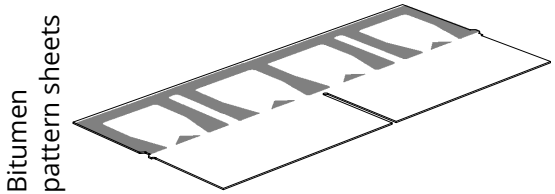
R2
x 3



R1
x 2

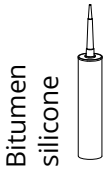


R3
x 8pcs for RC 2.4
9pcs for RC 2.6

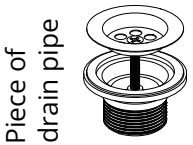


R4
x 7 pkg 6pcs for RC 2.4
8 pkg for RC 2.6

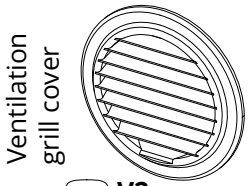
C1
x 2



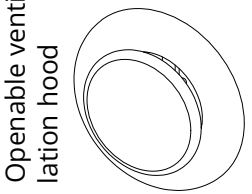
C2
x 2



V1
x 1

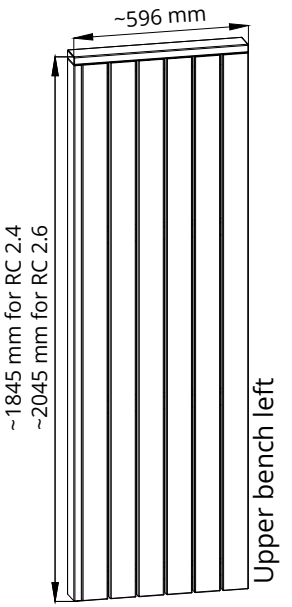


V2
x 5

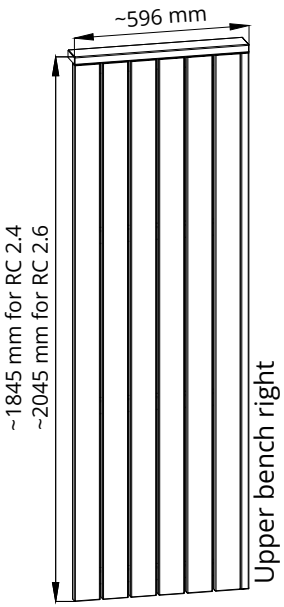


V3
x 1

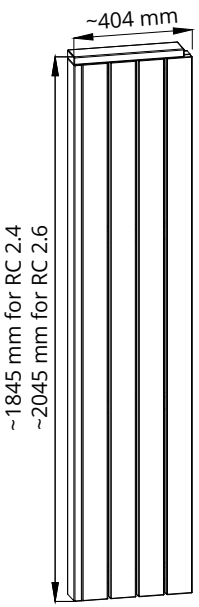
Detail list 2



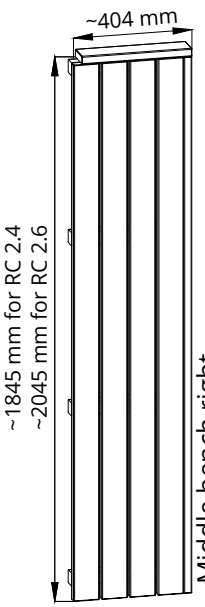
I1a
x 1



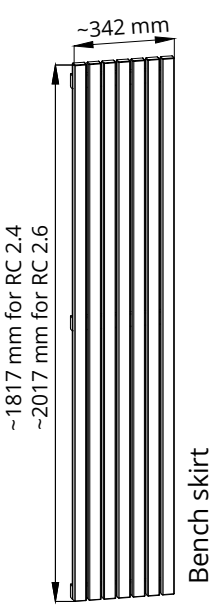
I1b
x 1



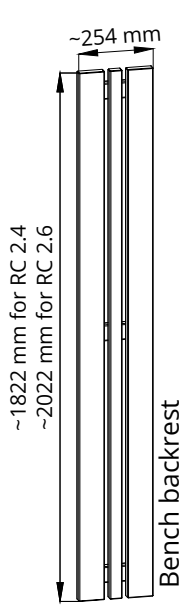
I2a
x 1



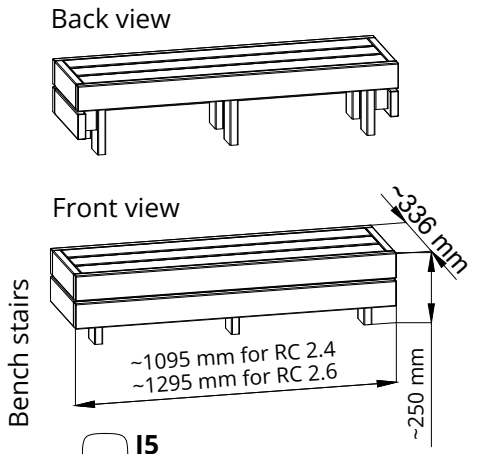
I2b
x 1



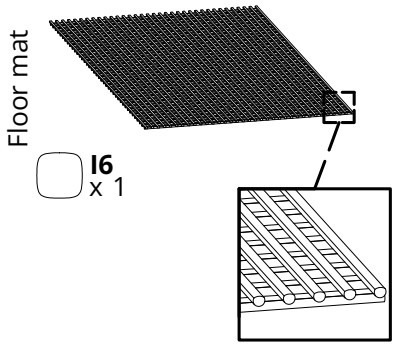
I3
x 2



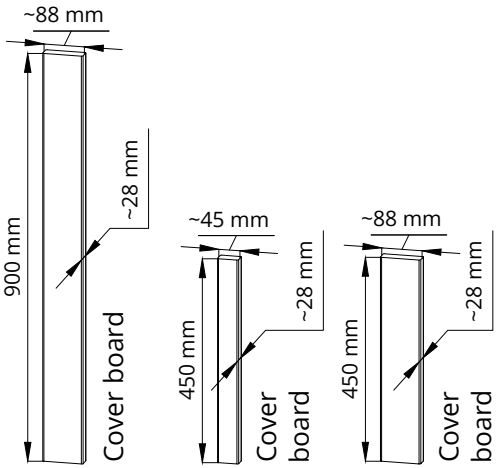
I4
x 2



I5
x 2



I6
x 1

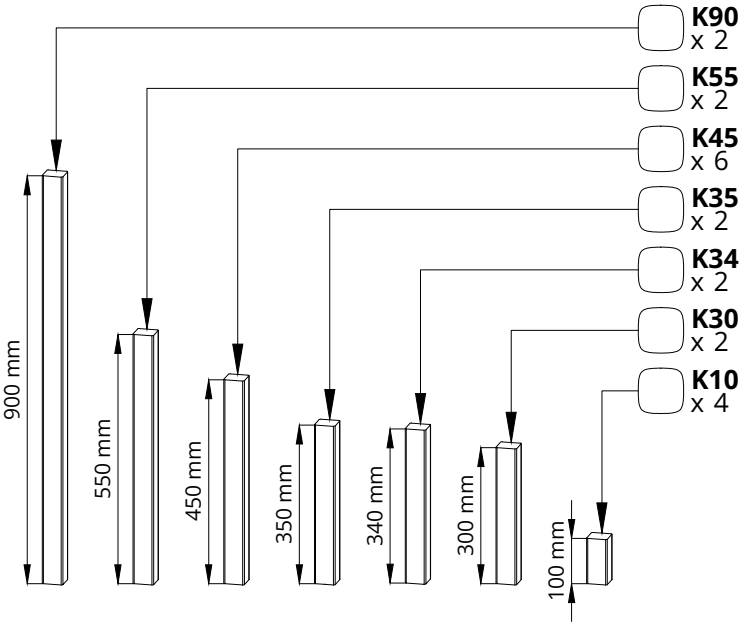


D3
x 2

D4
x 8

D5
x 2

K Square woods 45x45mm



K90
x 2

K55
x 2

K45
x 6

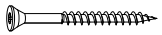
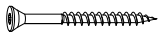
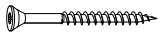
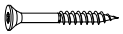
K35
x 2

K34
x 2

K30
x 2

K10
x 4

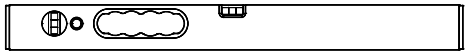
Detail list 3

Nails and screws (Scale 1:2)	Area of use	Name in in. manual	Screw size	Quantity	
	Mainly for construction inside and outside	S7	Screws 4,5x80 for Spruce Screws 4,2x75 for Thermo	x150	☐
	For fixing the door(s)	S6.2	Screws 4,2x75	x25	☐
	For fixing the side wall end coverings	S6.1	Screws 4,5x70 (black coated)	x60	☐
	Mainly for construction inside and outside	S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x200	☐
	Not in use in this sauna Only for the window(s)	S4	Screws 4,2x55	x0	☐
	For fixing front door moldings (screws is attached to the door moldings)	S3.2	Screws 4,5x50	x14	☐
	Not in use in this sauna Only for the window moldings	S3.1	Screws 3x40	x0	☐
	Mainly for construction inside and outside	S2	Screws 3x40	x15	☐
	Mainly for construction inside and outside	S1	Screws 3x30	x18	☐
	During roof installation	R5	Nail 2,5x20	1kg	☐

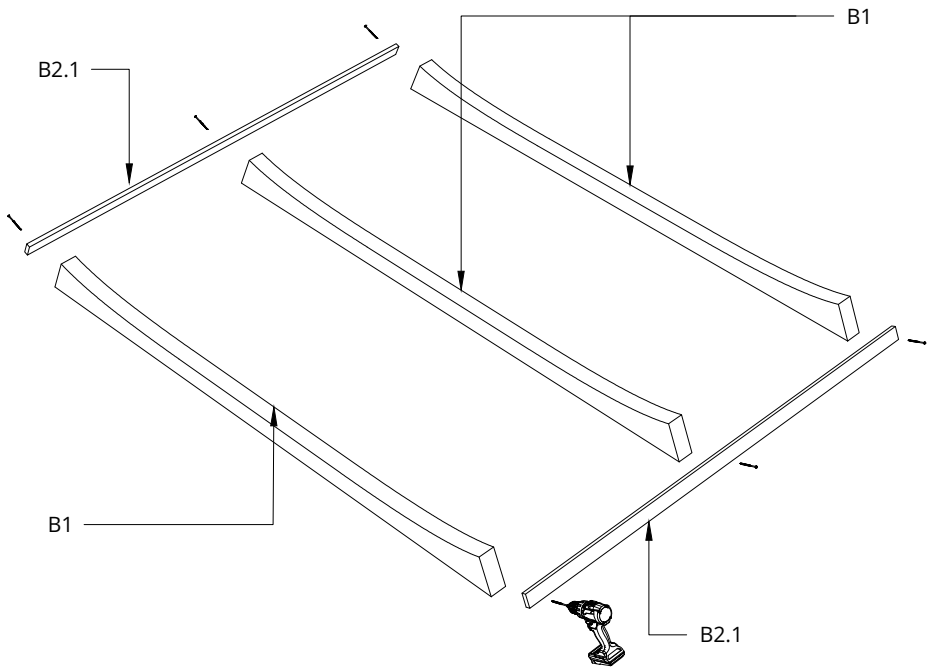
Detail list 4

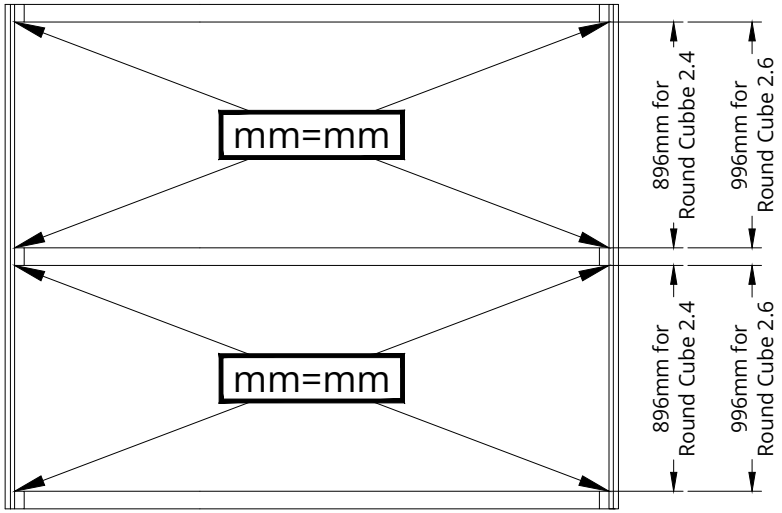
S7	Screws 4,5x80 for Spruce Screws 4,2x75 for Thermo	x6

NB! use a level



The base of the sauna must be level!

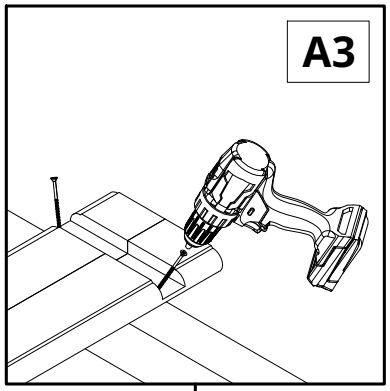


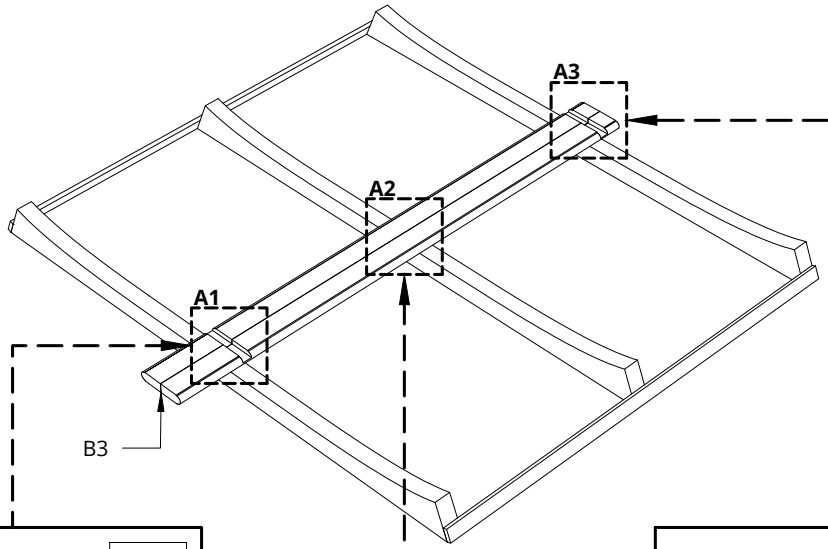


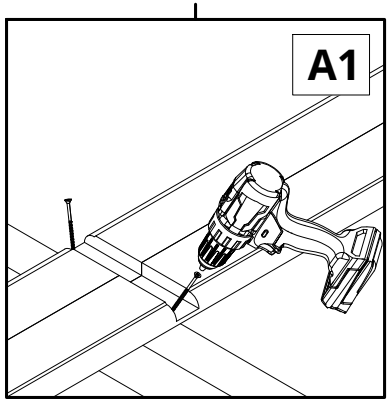
S7	Screws 4,5x80 for Spruce Screws 4,2x75 for Thermo	x6

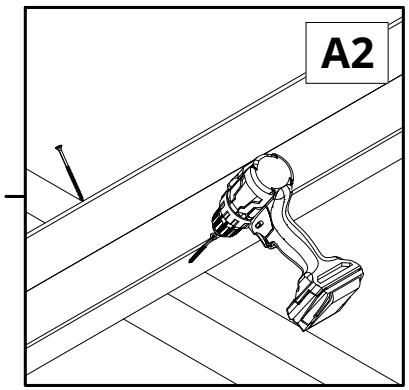
Use two screws for point A1, A2 and A3 (see sketch) .

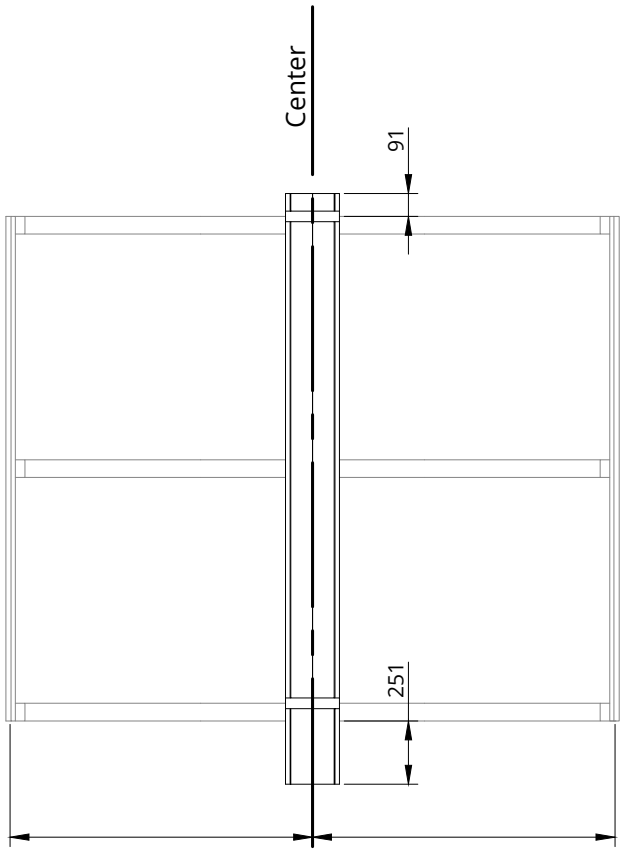
Please countersink the screw head!











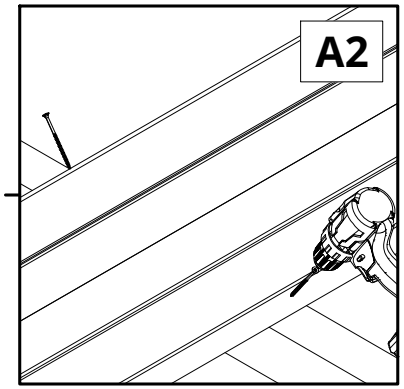
mm=mm

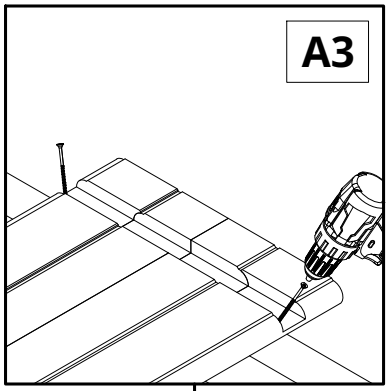
S7	Screws 4,5x80 for Spruce Screws 4,2x75 for Thermo	x60

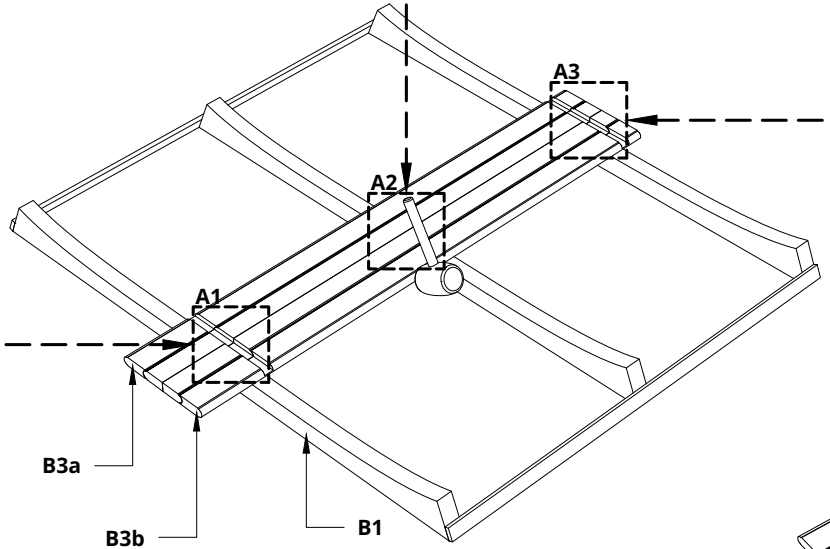
Use a rubber mallet to tap the planks together.

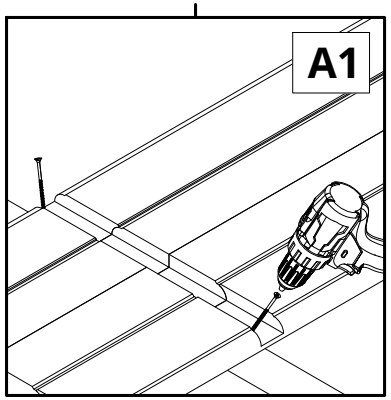
Screw each plank B3a and B3b to the foundation B1 with a screw. ~10 pieces on each side left B3a and right B3b.

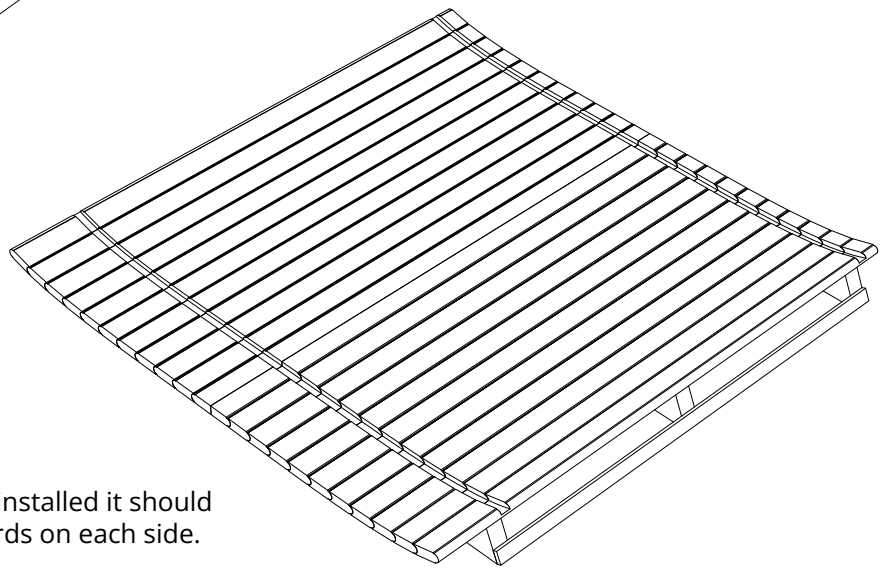
Please countersink the screw head!



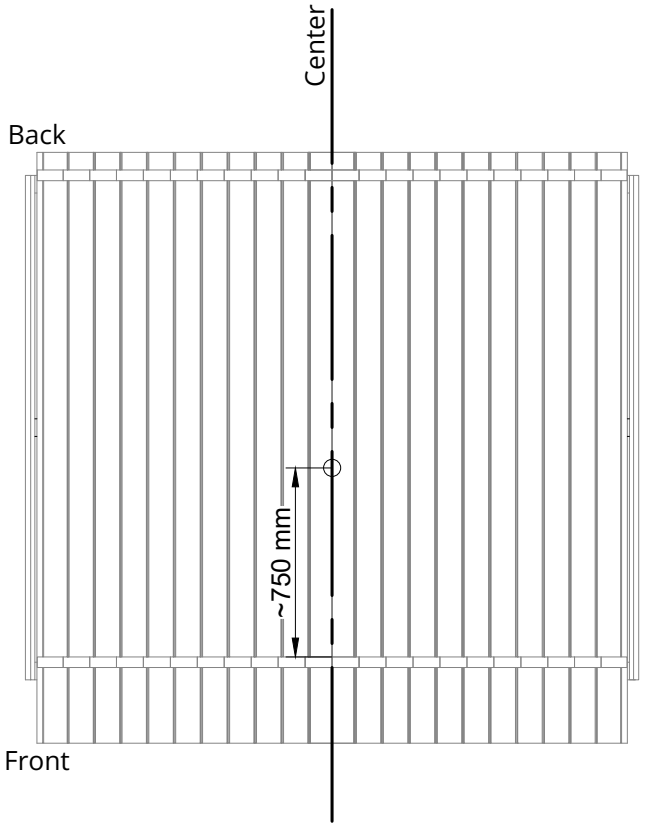






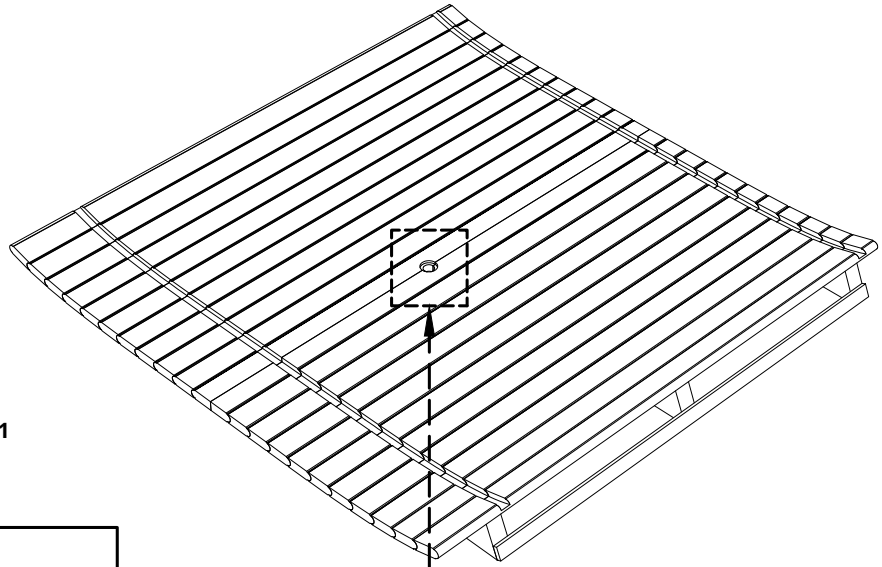


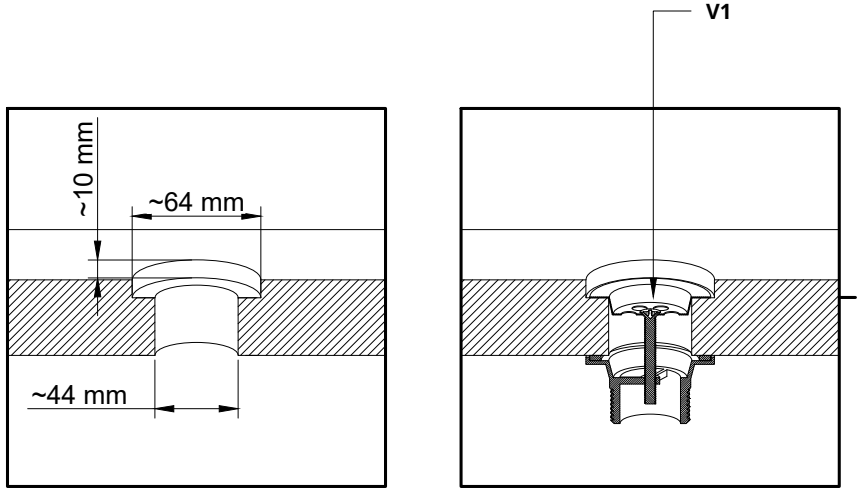
When the boards are installed it should look like this. ~10 boards on each side.



Before installation of the drain pipe,
hole must be cut with a hole saw.

Install a piece of drain pipe V1.

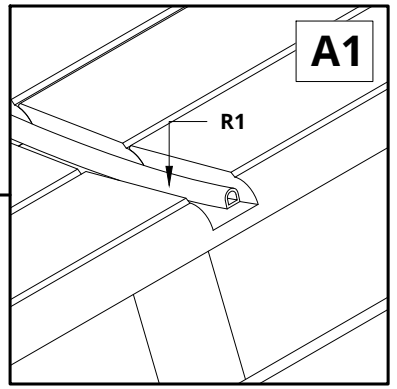


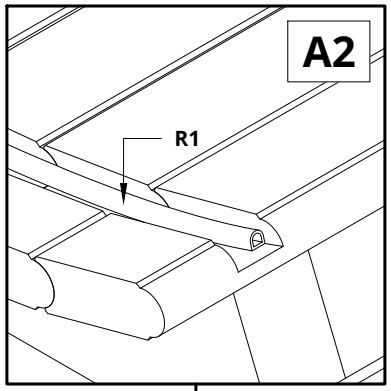


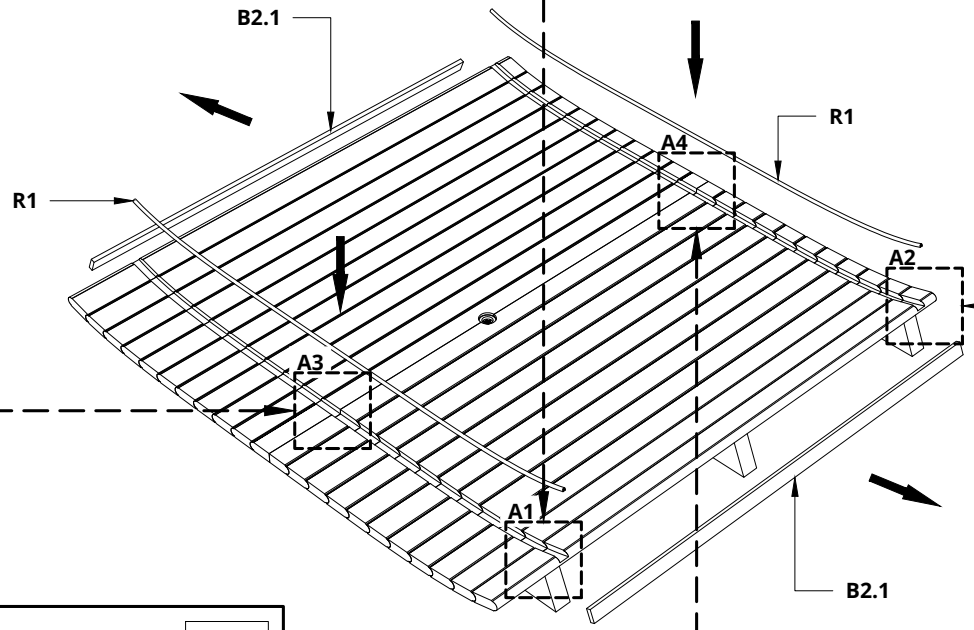
Lay R1 (rubber seal) to the inside of the groove as shown in picture A3 and A4.

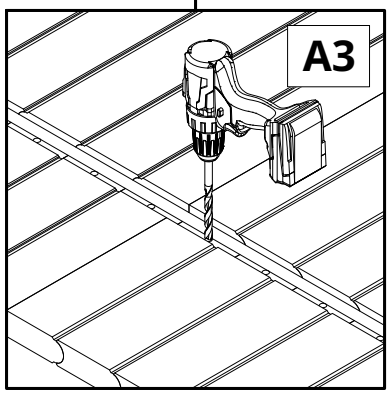
Drill 10 mm hole in each plank, in the front wall groove and in the back wall groove to the outside as shown in the picture A1 and A2.

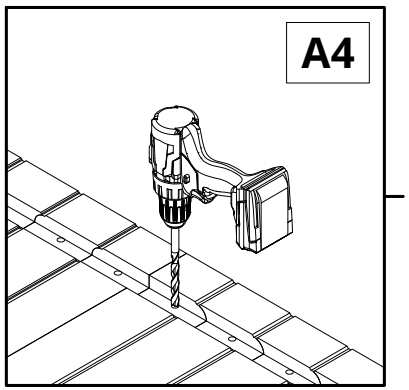
Remove the connecting beam B2.1 on both sides.



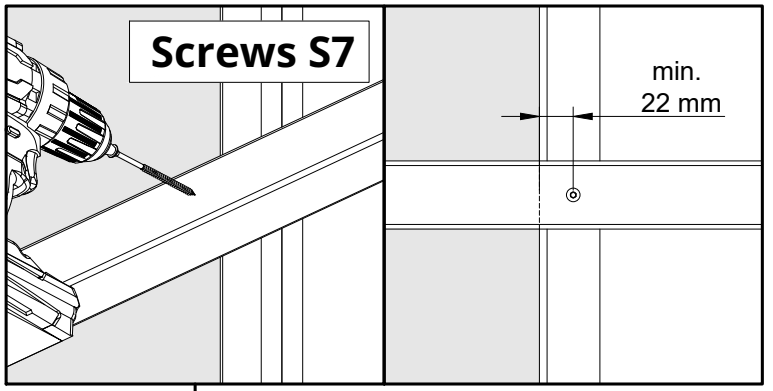


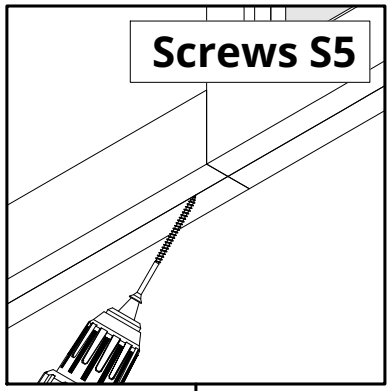


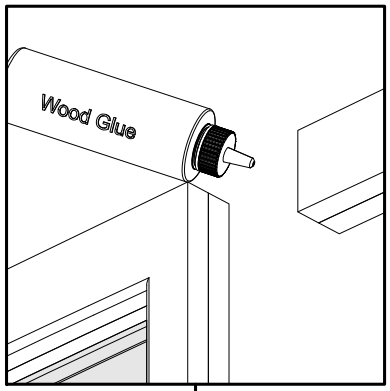




S7	Screws 4,5x80 for Spruce Screws 4,2x75 for Thermo	x8
S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x4





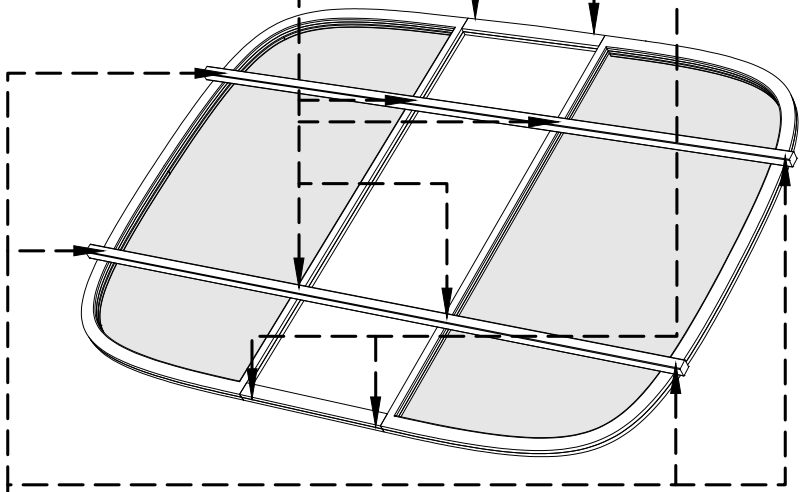


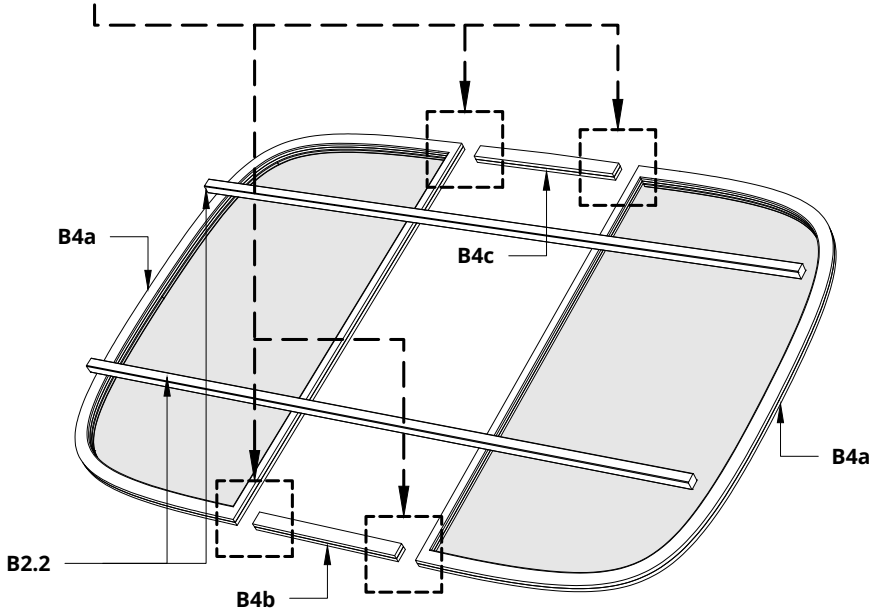
Preparation of the front wall.

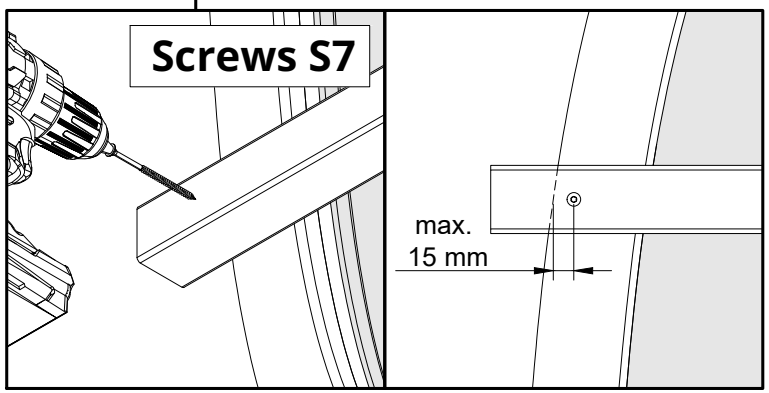
When assembling the front wall, first use glue between the wall pieces and then screw the pieces together and add the wall reinforcements B2.2 to the inner side of the wall.

Let the glue dry according to the glue manufacturer's recommendations.

Please countersink the S5 screw head!

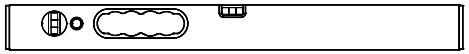


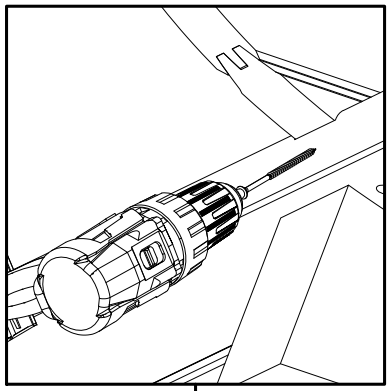


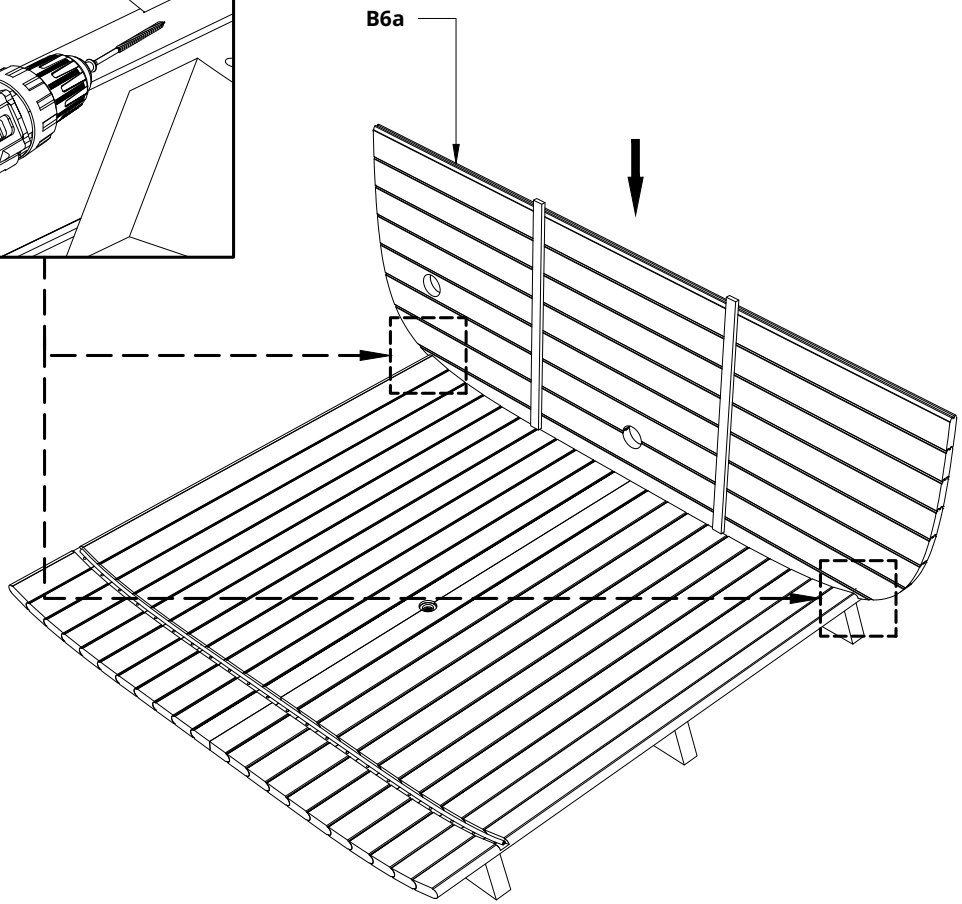


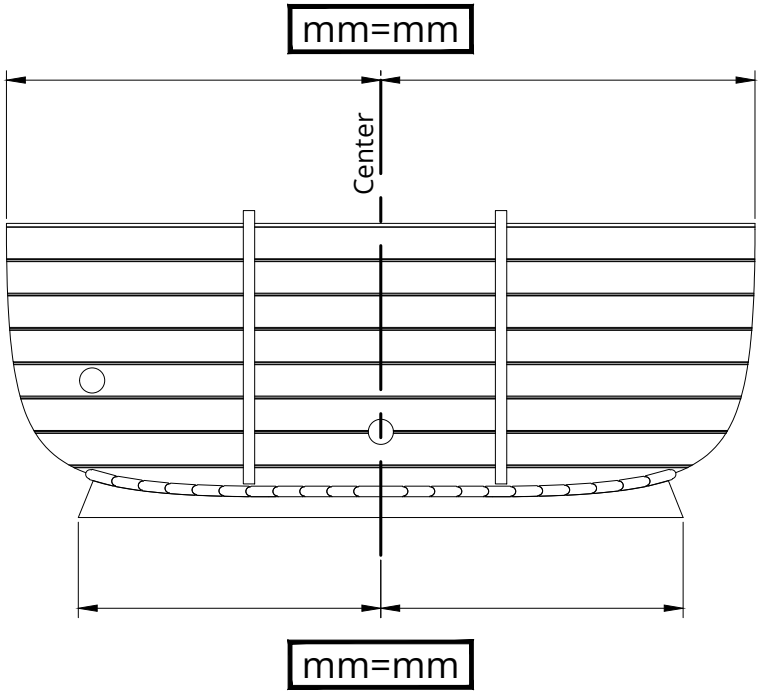
S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x2

NB! use a level









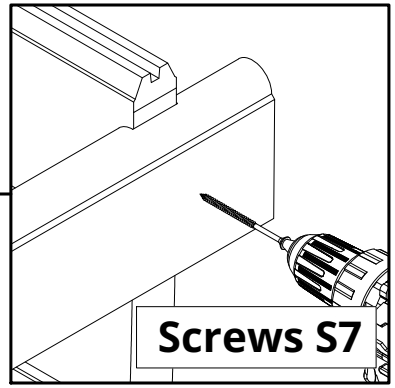
First install the lower part of the back wall. The lower part of the back wall must be in the center of the base.

If the lower part of the back wall is in place, then it must be fixed with screws. The screw locations are shown in the picture.

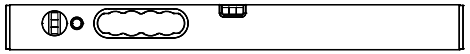
Please countersink the screw head!

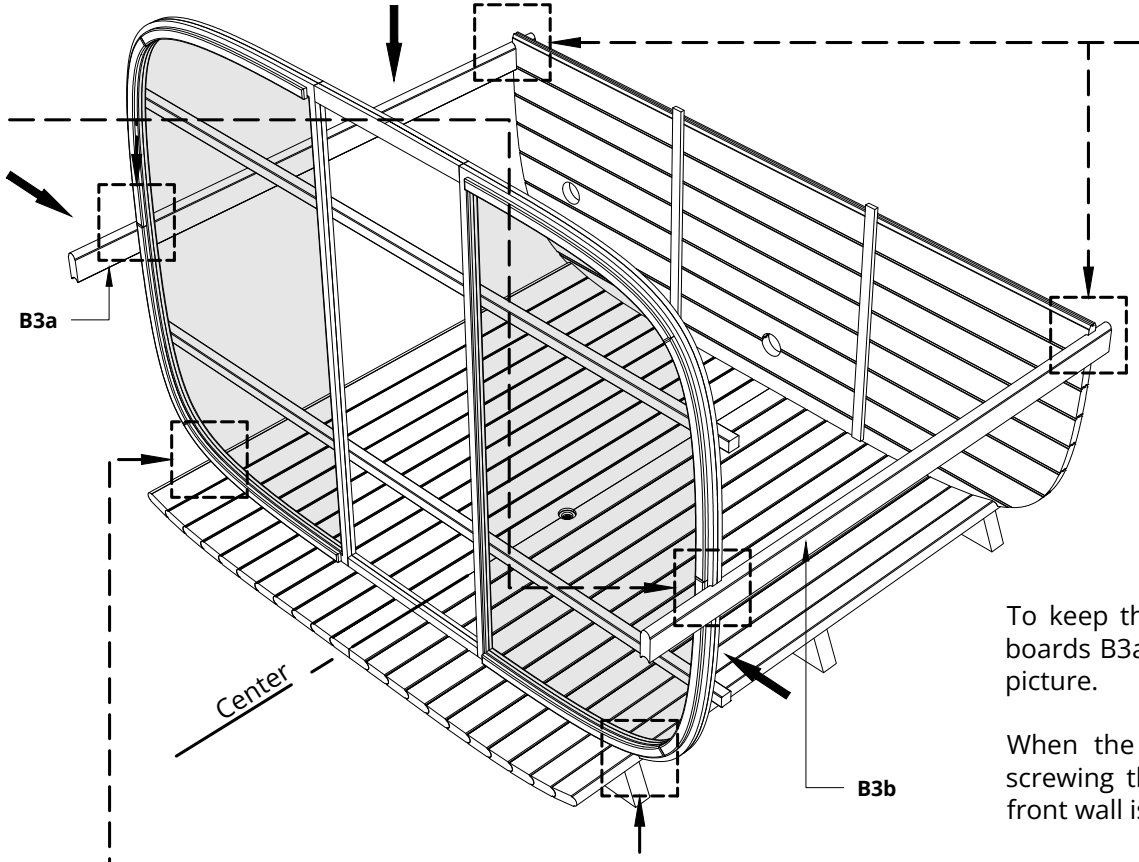
S7	Screws 4,5x80 for Spruce Screws 4,2x75 for Thermo	x4
S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x2

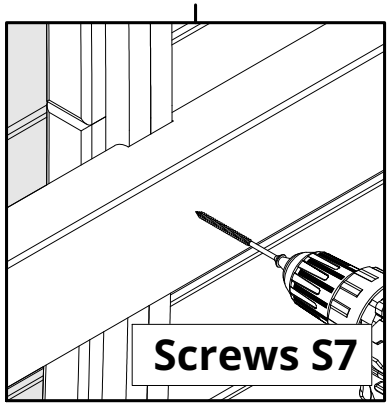
When installing the front wall, make sure that it stays in the center!

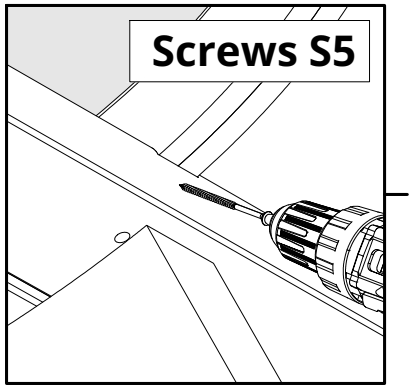


NB! use a level









To keep the front wall upright, use the side wall boards B3a and B3b. Install them as shown in the picture.

When the support boards are in place, before screwing the front wall to the base, check if the front wall is in the center.

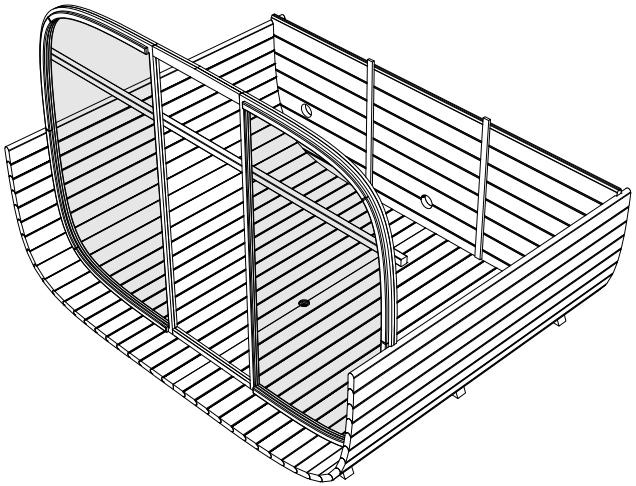
Please countersink the S5 screw head!

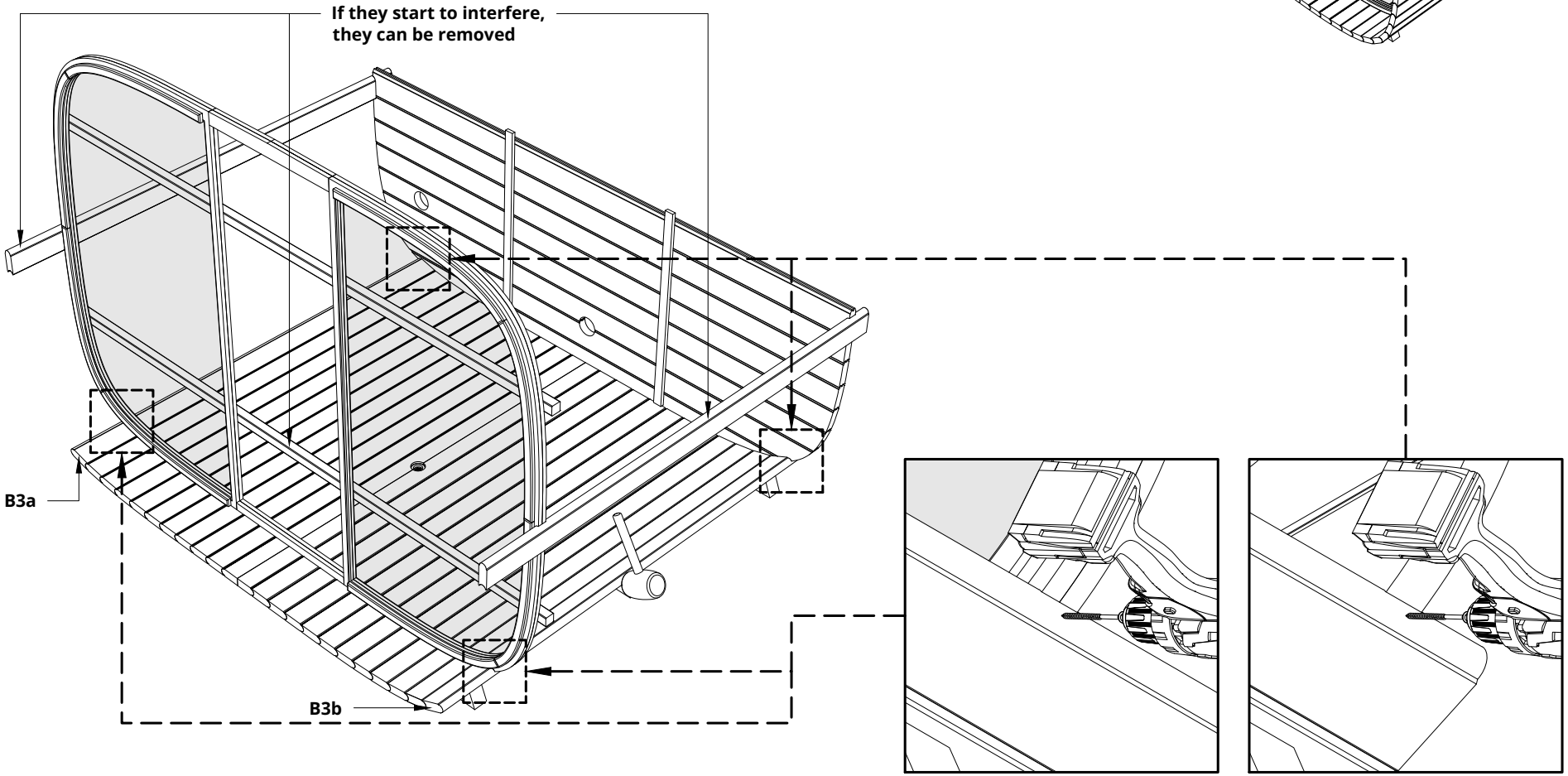
S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x40

When the front wall is attached, start building the side walls on the left B3a and on the right B3b. Use a rubber mallet to tap the boards into place and then fasten with screws.

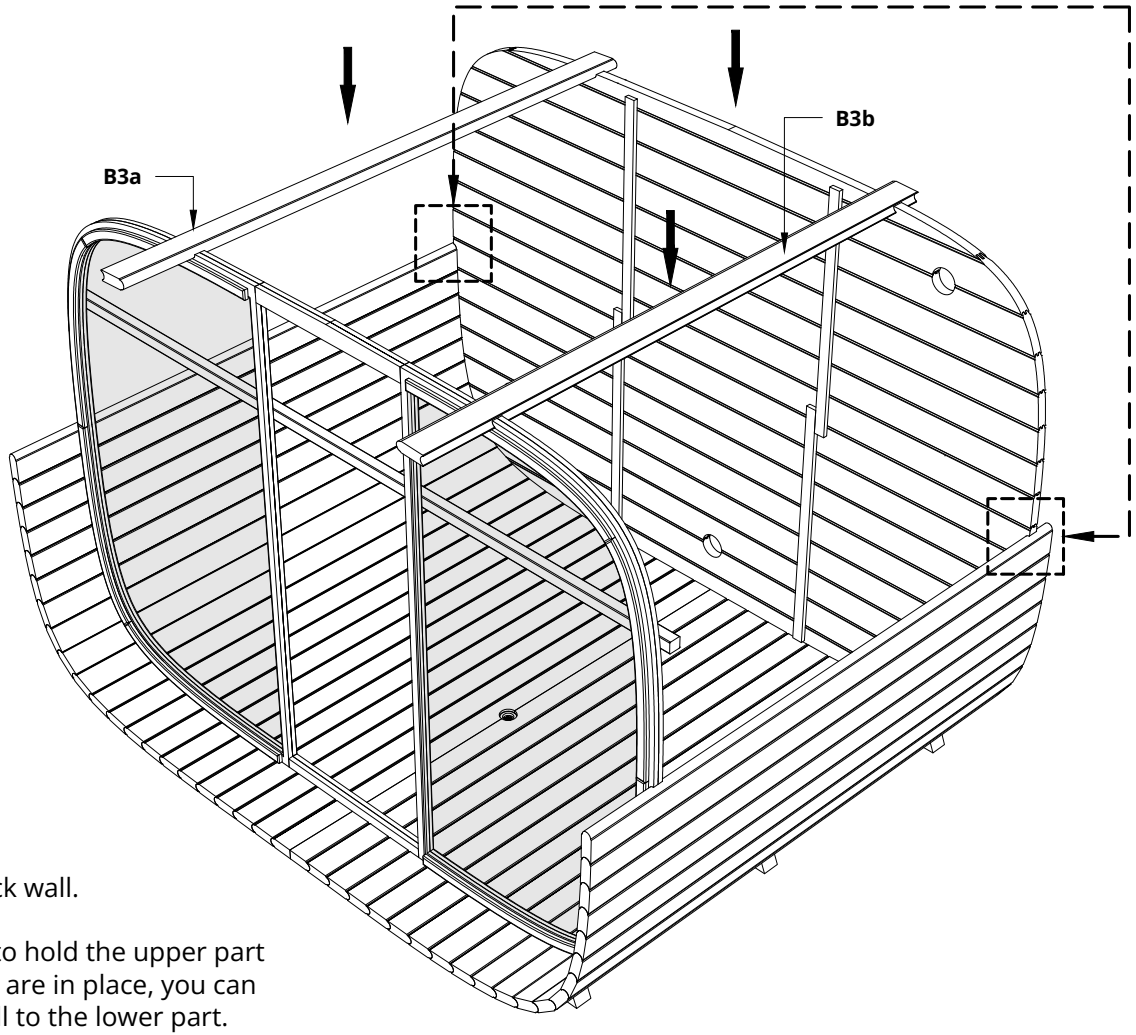
Build the side walls to the upper edge of the lower part of the back wall as shown in the picture.

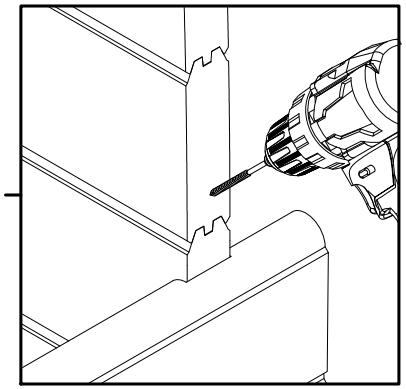
Please countersink the S5 screw head!





S7	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x2



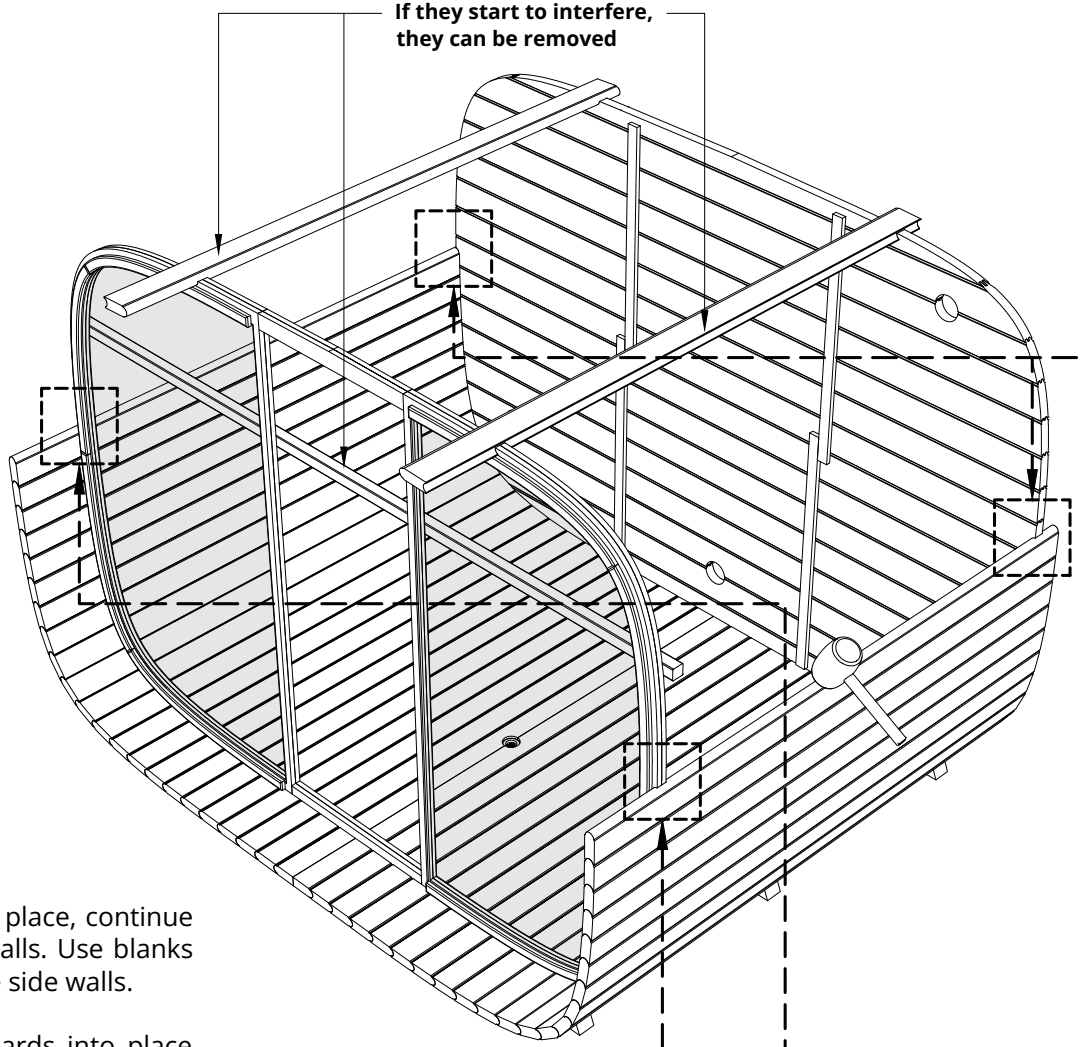


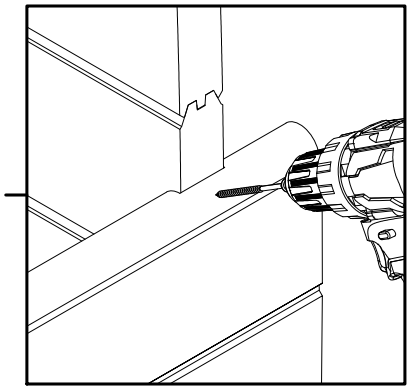
Now install the upper part of the back wall.

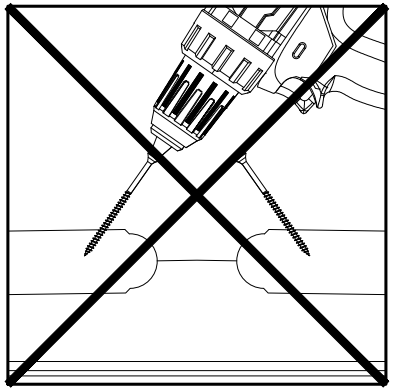
Install support boards B3a and B3b to hold the upper part of the back wall securely. When they are in place, you can screw the upper part of the back wall to the lower part.

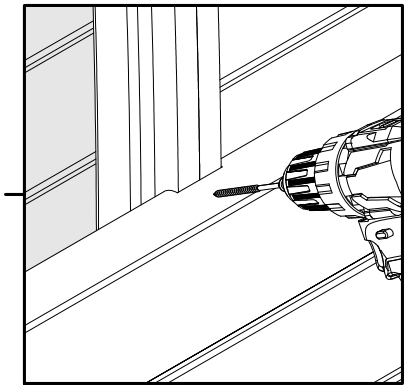
Please countersink the screw head!

S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x84







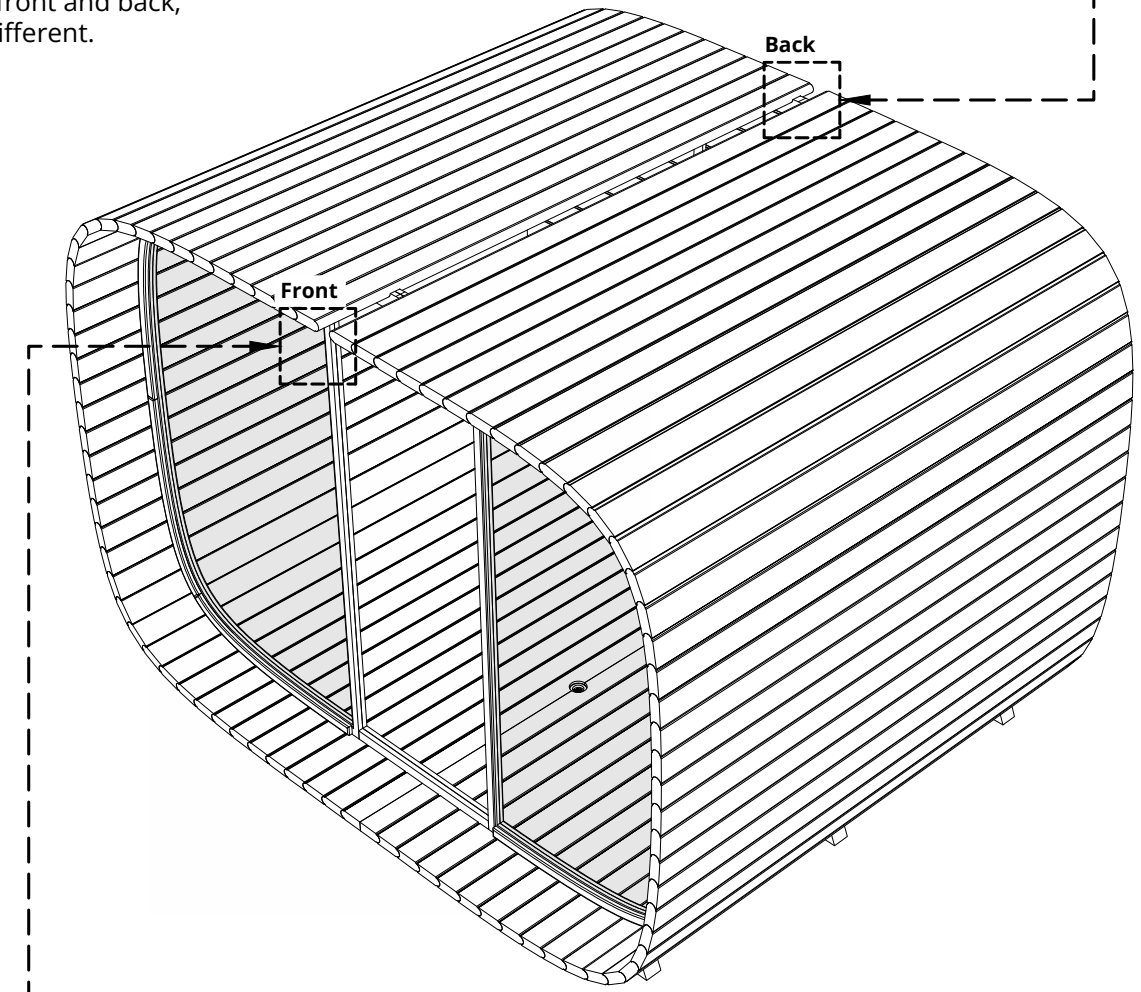


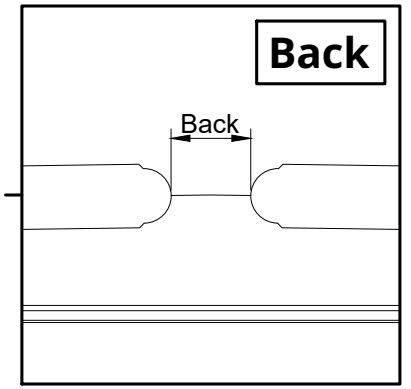
When the top of the back wall is in place, continue with the construction of the side walls. Use blanks B3a (left) and B3b (right) to build the side walls.

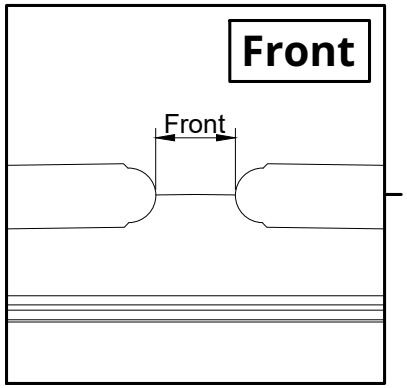
Use a rubber mallet to tap the boards into place and then fasten with screws.

Please countersink the screw head!
Please do not screw the screws in on the last whole blanks immediately.

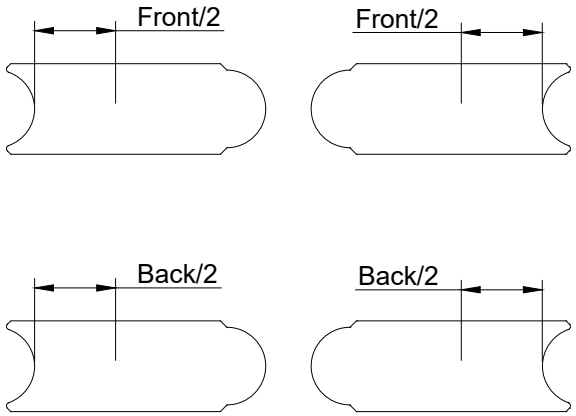
Please measure the gap front and back,
the dimensions can be different.

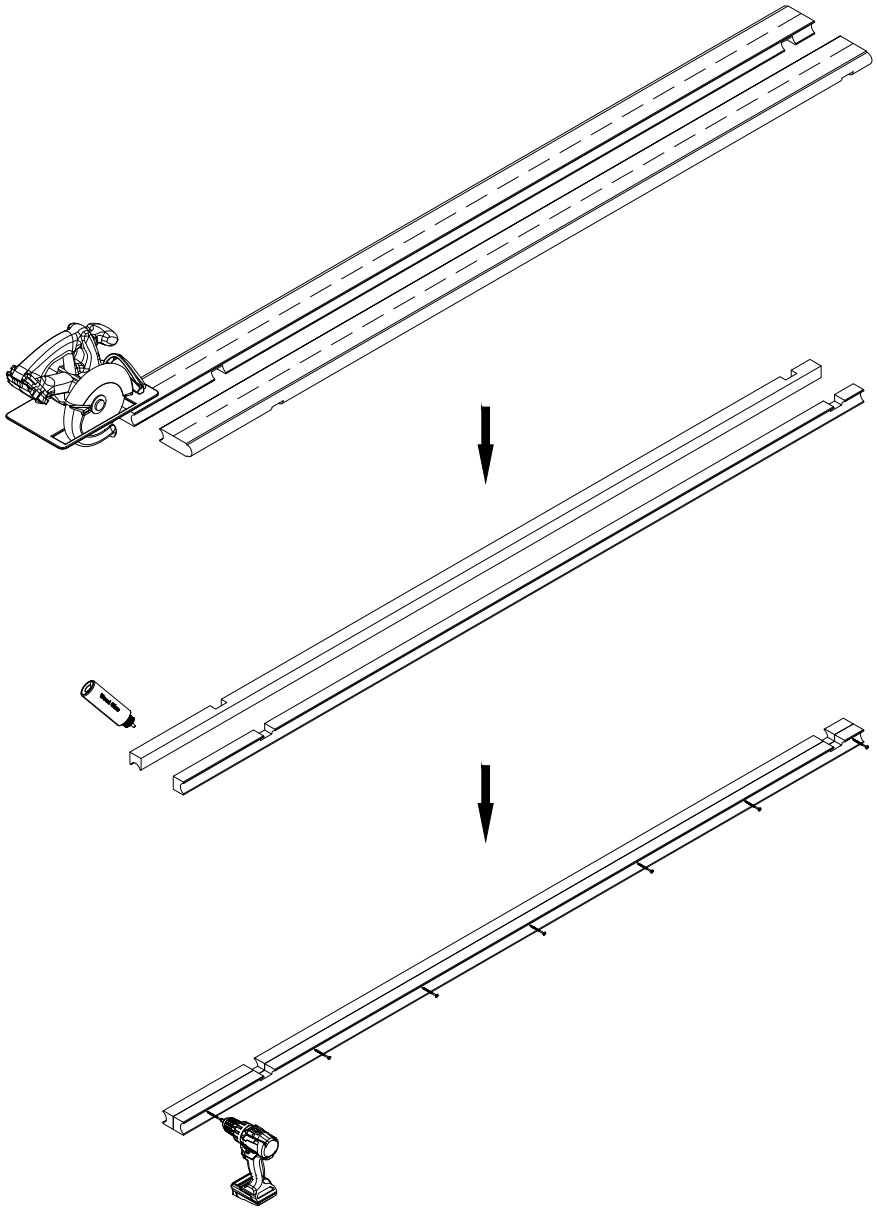






S2...7	Screws 3x40 ... 4,5x80	x7



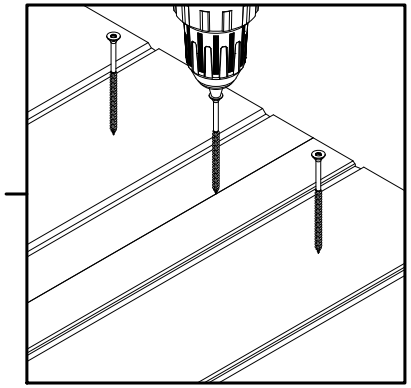


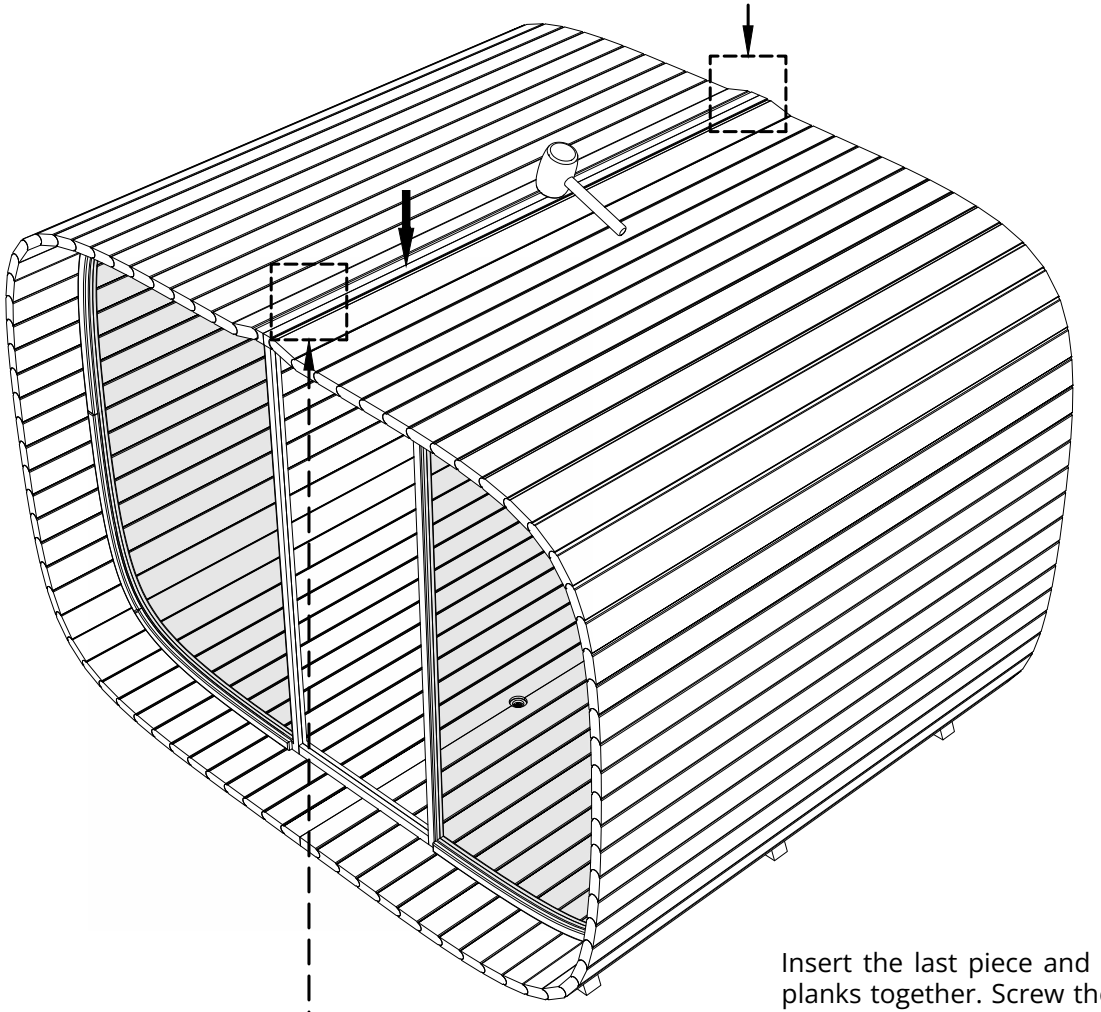
Divide the measurement by two and transfer the measurements to the last two planks. Connect the dimensions on the plank with a line and cut off these ends.

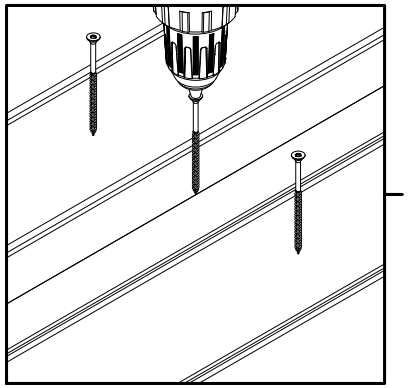
Glue the two freshly cut boards with wood glue and connect them with 7 pieces of 3x40 ... 4.5x80 screws (the length of the screws depends on the final width of the last two planks cut). Wipe off excess glue with a cloth and then use sandpaper to smooth out the gap.

Please countersink the screw head!

S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x6

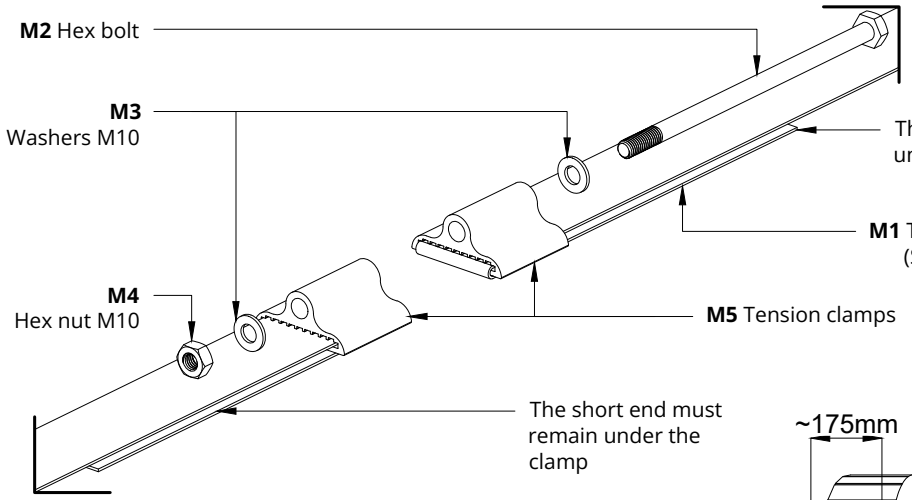






Insert the last piece and use a rubber mallet to tap the planks together. Screw the loose planks to the walls with screws.

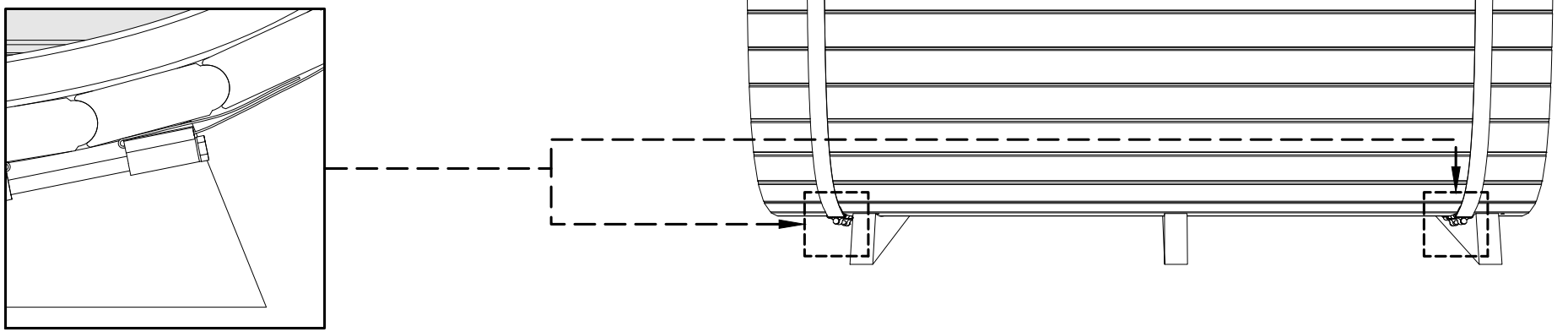
Please countersink the screw head!

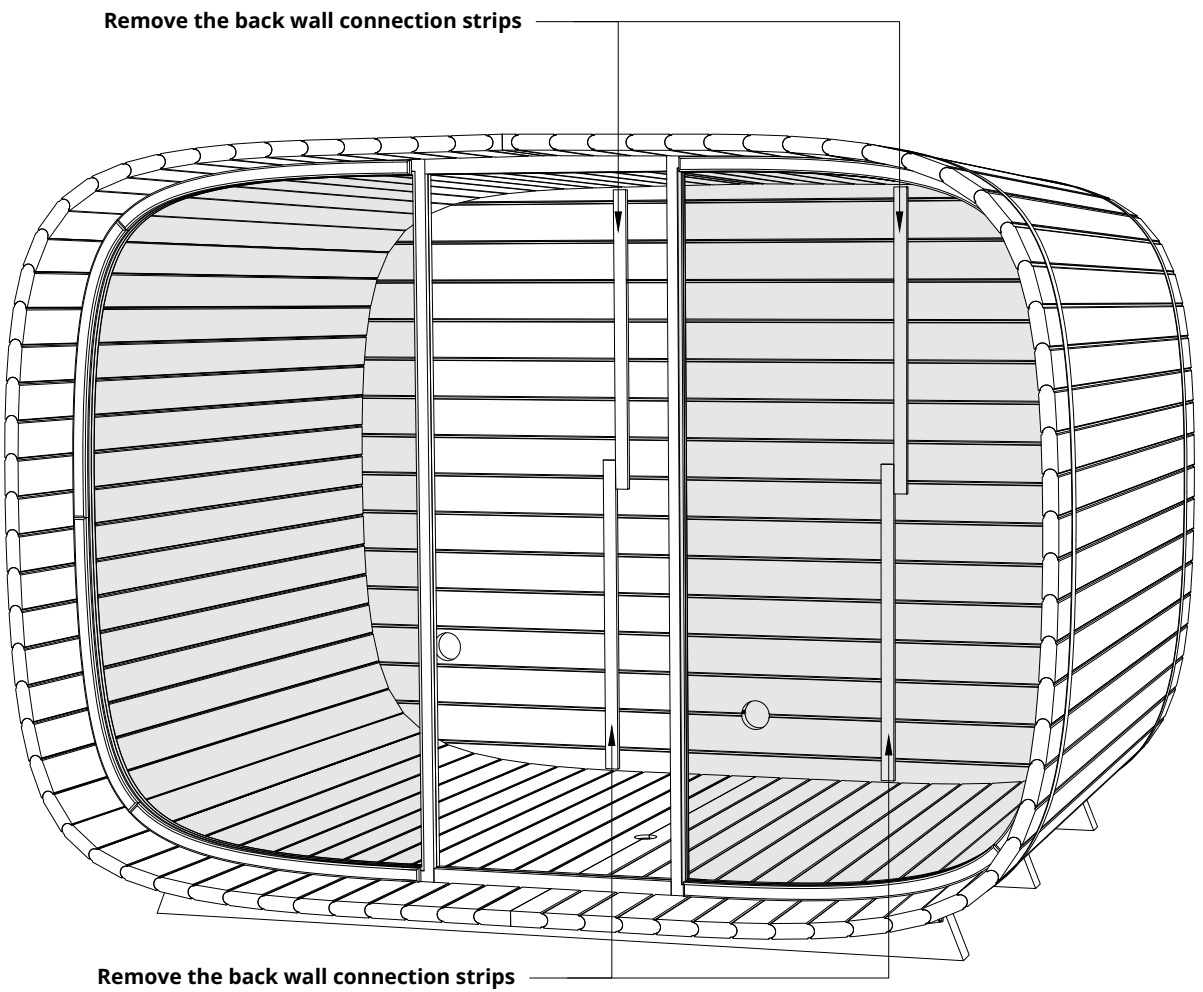


Place the tension bands M1 (Steel band) around the side walls and thread the bands into the eyelet as follows (see sketch above).

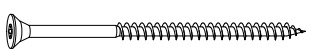
Hex nuts and bolts must be tightened as long as the planks are stationary in all directions.

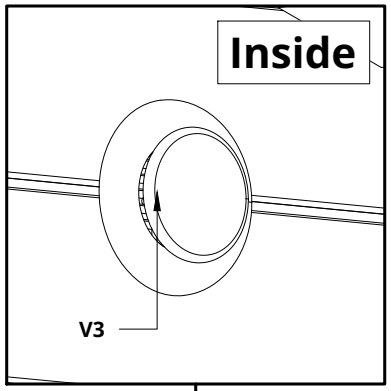
The tension band and clamps must be placed as shown in the picture below.

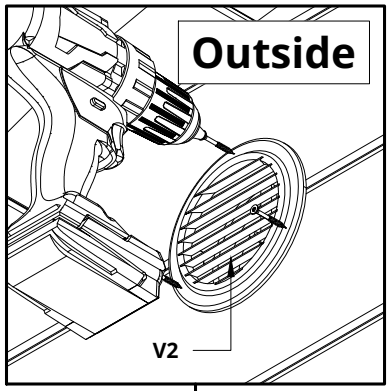


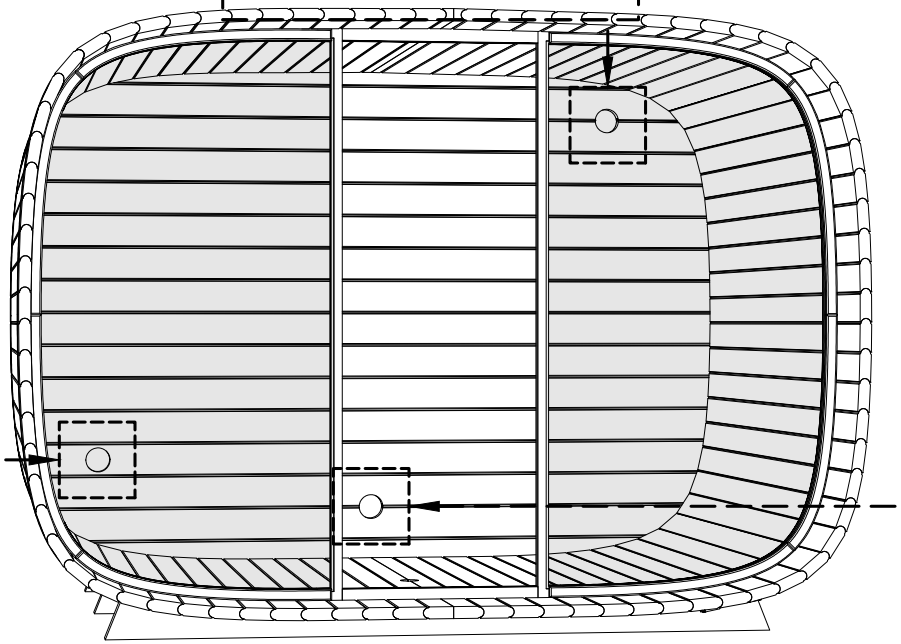

Remove the back wall connection strips
Remove the back wall connection strips

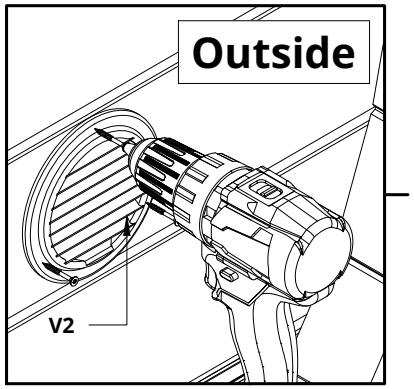
S1	Screws 3x30	x18

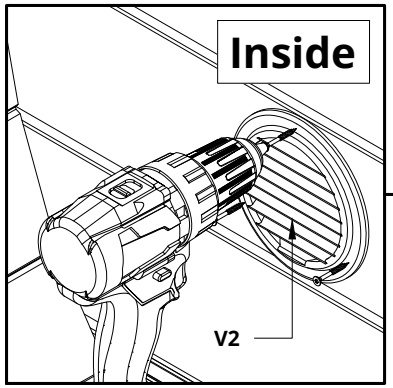


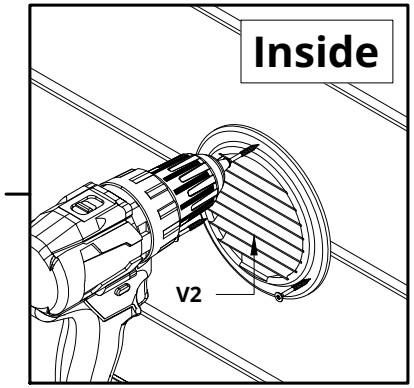


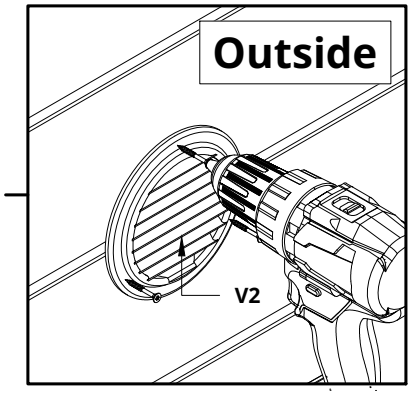








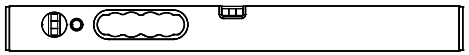




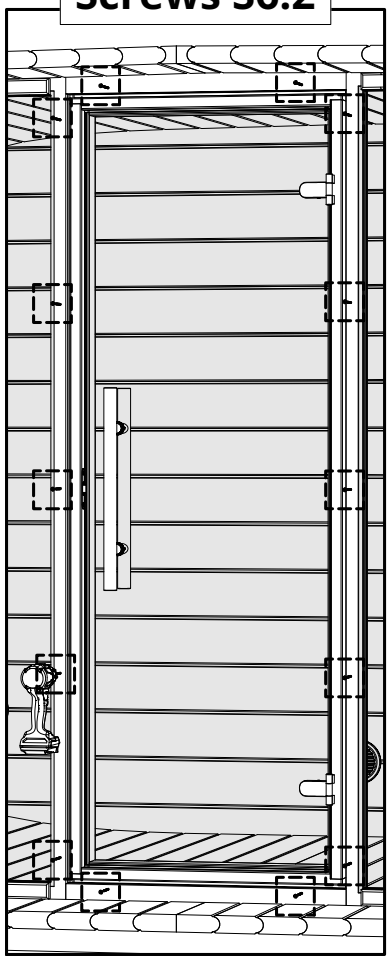
The inner and outer ventilation grilles V2 and adjustable cover V3 are screwed with 3 screws.

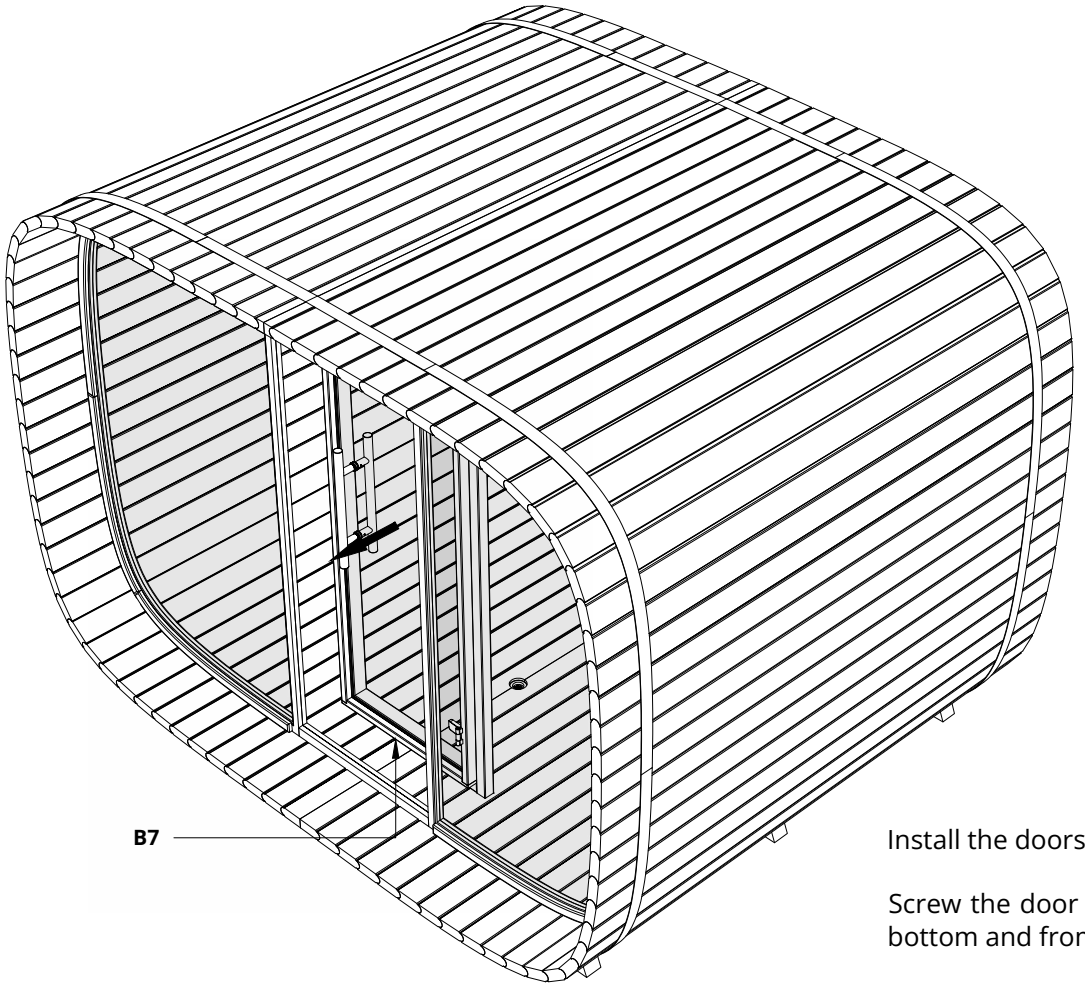
S6.2	Screws 4,2x75	x14
S3.2	Screws 4,5x50	x14

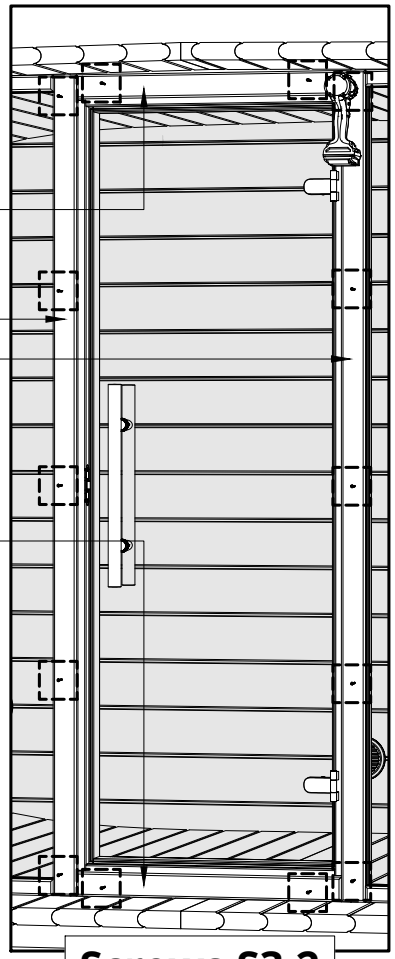
NB! use a level



Screws S6.2







Screws S3.2

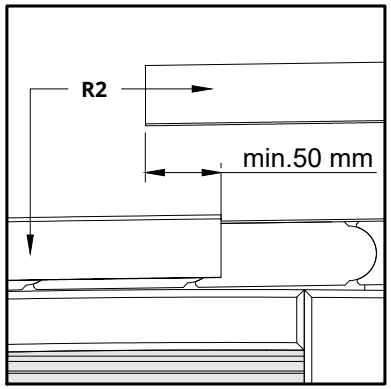
Install the doors from inside (shown in the picture).

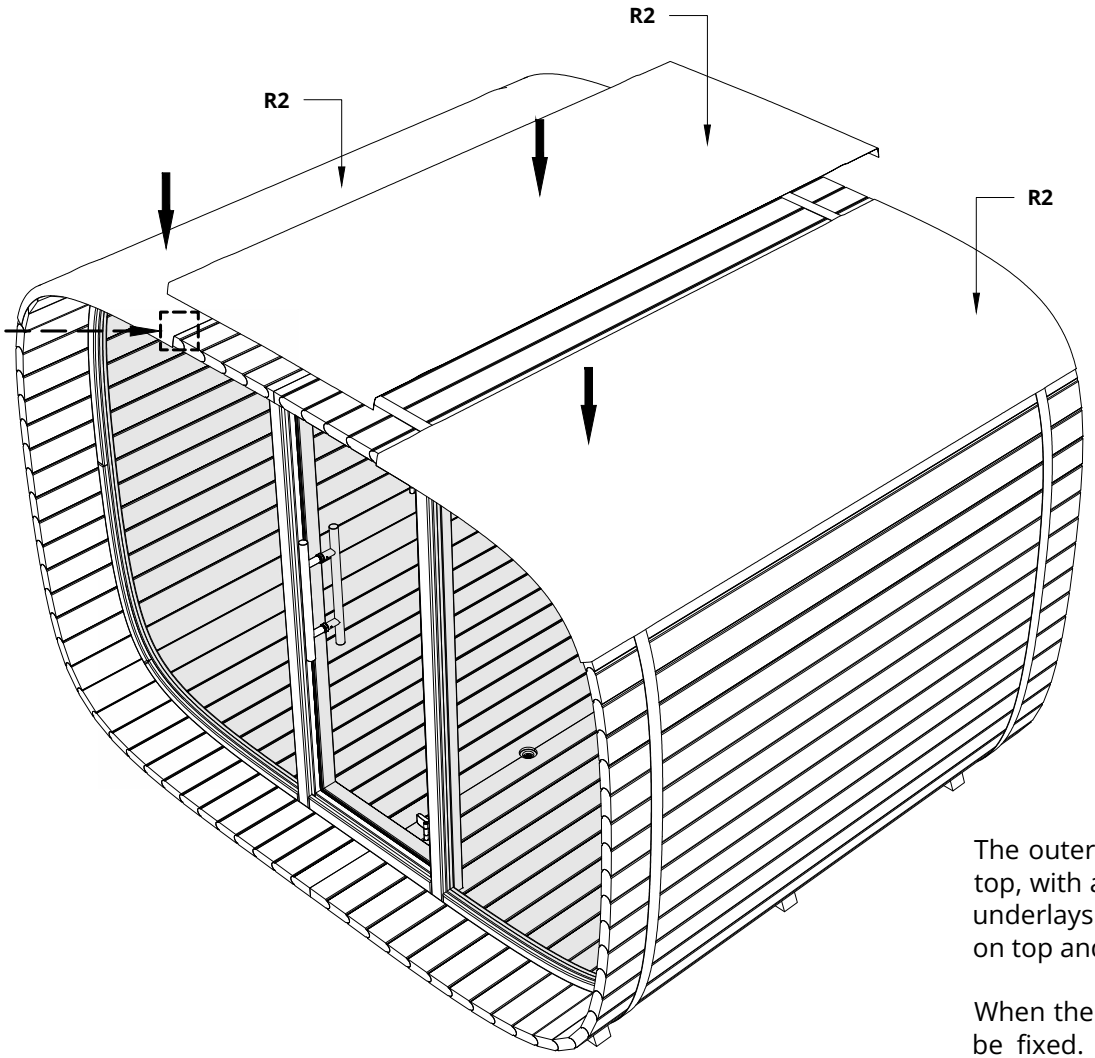
Screw the door from the sides with 5 screws from the bottom and from the top with 2 screws.

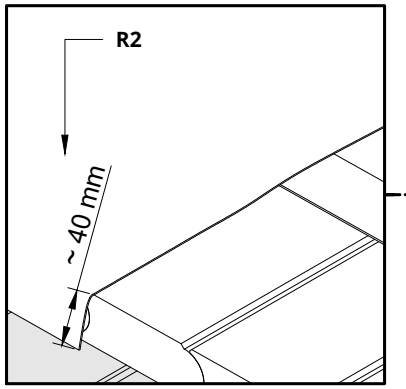
If the door is in place, install the door moldings, top with 2 screws and bottom with 2 screws and the sides with 5 screws.

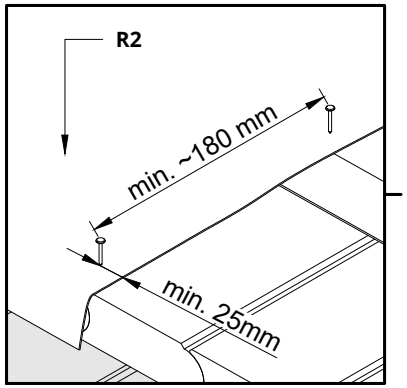
Please countersink the screw head!

R5	Nail 2,5x25









Install first outer underlayment so that the middle underlay overlaps the outer ones by at least 50 mm to cover the nail heads.

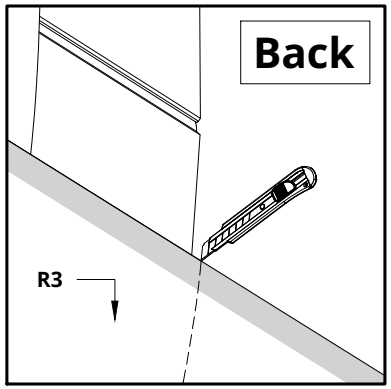
The underlay must extend over the front end and back end at least by 40 mm.

The outer underlays are fixed with nails from the top, with a gap of about 180 mm. When the outer underlays are in place, put the middle underlay on top and use a heat source to make it stick.

When the underlays are in place, their ends must be fixed. They must be bent before fixing with nails.

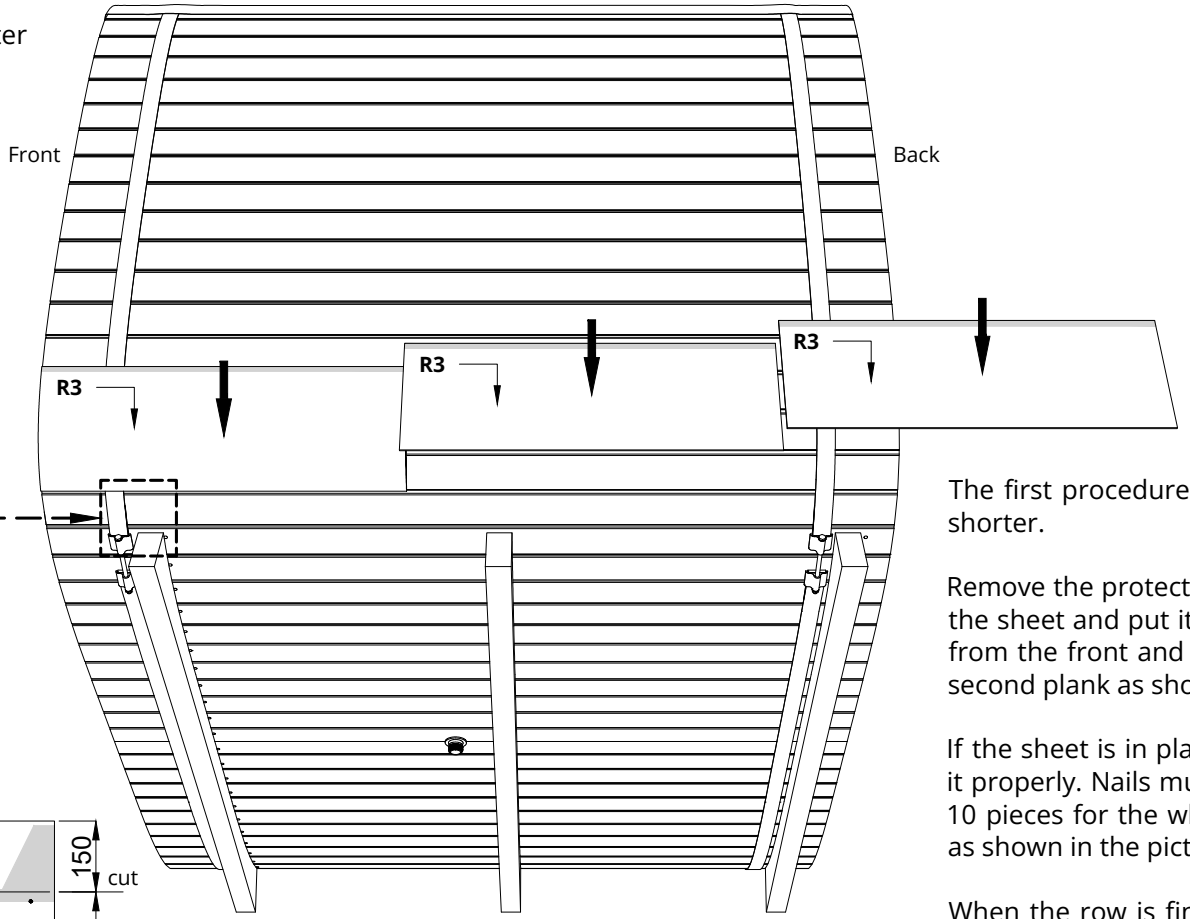
Use a heat source when you bend them, otherwise they may break or leave cracks.

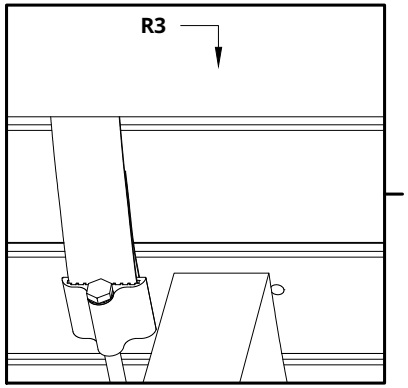
R5	Nail 2,5x25

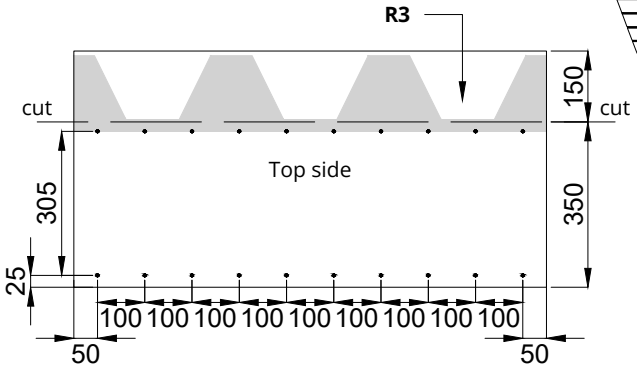


The base sheet of the first row must be installed first.

Sheets are self-adhesive, for better adhesion use a heat source.







Repeat these steps on the other side as well!

The first procedure is to cut the sheet 150 mm shorter.

Remove the protective films from the bottom of the sheet and put it in place by starting the row from the front and bottom of the sauna on the second plank as shown in the pictures.

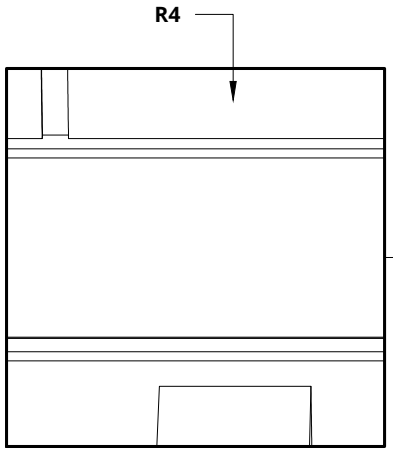
If the sheet is in place, nails must be used to fix it properly. Nails must be placed every 100 mm, 10 pieces for the whole sheet below and above as shown in the picture.

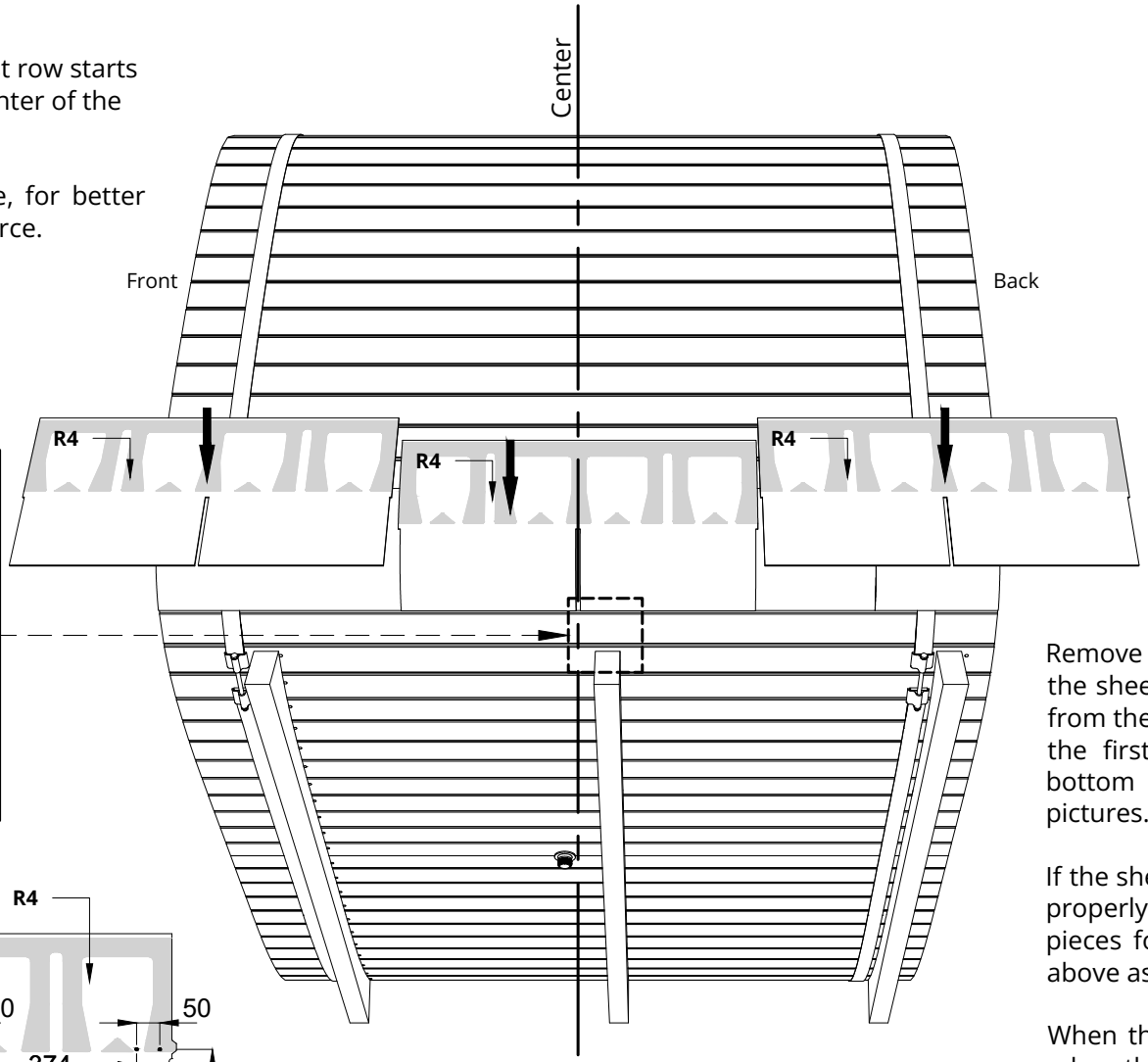
When the row is finished and extends over the edge, it must be cut off and the leftovers can be used to complete the row on the other side.

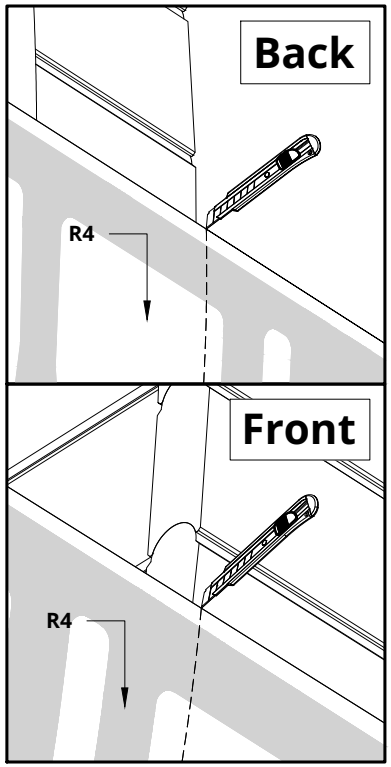
R5	Nail 2,5x25

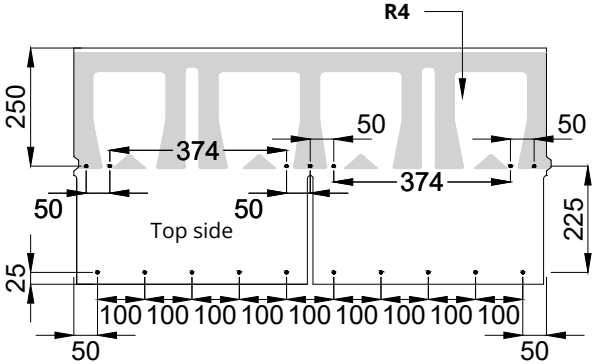
The first sheet of the first row starts from the bottom and center of the side wall of the sauna.

Sheets are self-adhesive, for better adhesion use a heat source.









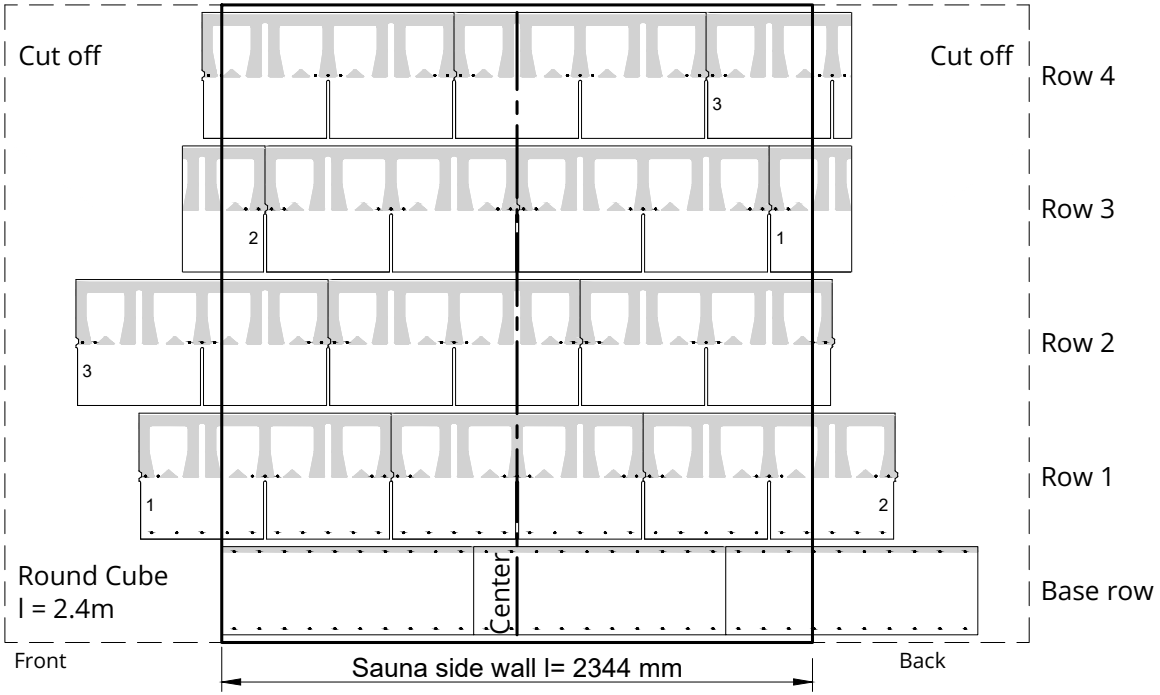
Repeat these steps on the other side as well!
(THE LOWER FASTENING NAILS ARE ONLY IN THE FIRST ROW)

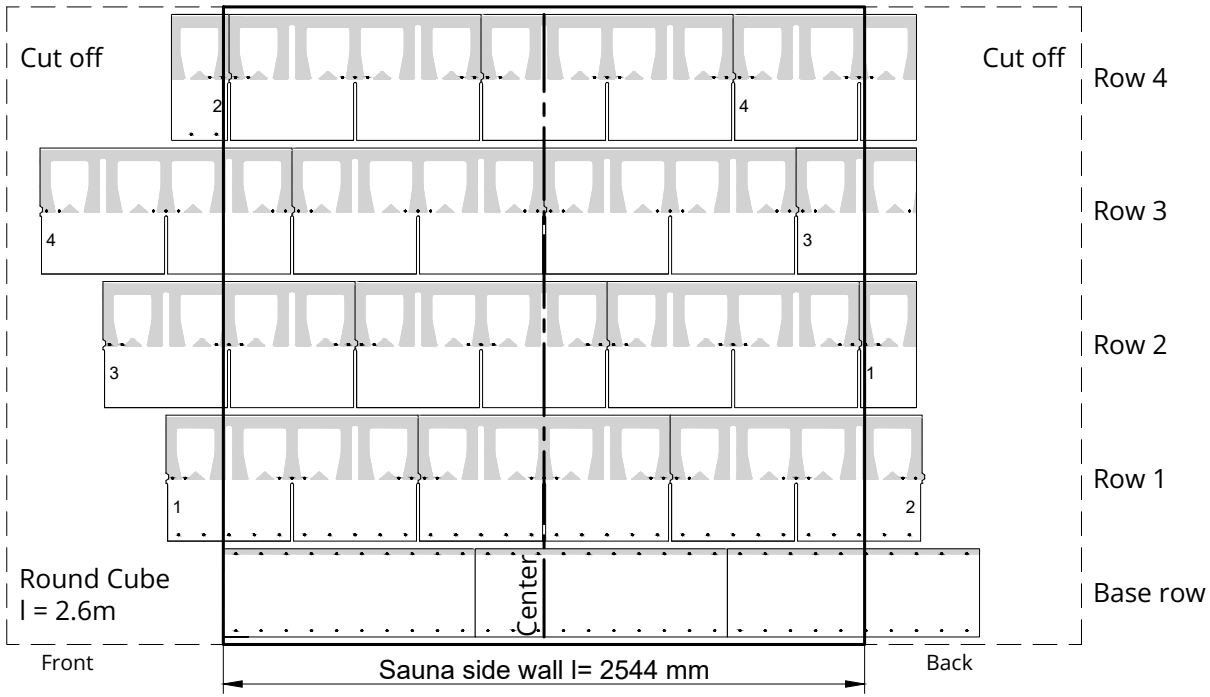
Remove the protective film from the bottom of the sheet and put it in place by starting the row from the bottom and center. The bottom edge of the first row sheet must be in line with the bottom edge of the base sheet shown in the pictures.

If the sheet is in place, nails must be used to fix it properly. Nails must be placed every 100 mm, 10 pieces for the whole sheet below and 7 pieces above as shown in the picture.

When the row is finished and extends over the edge, the excess must be cut off and the left-overs can be used in the following rows.

See page 22 for a recommendation on row arrangement.





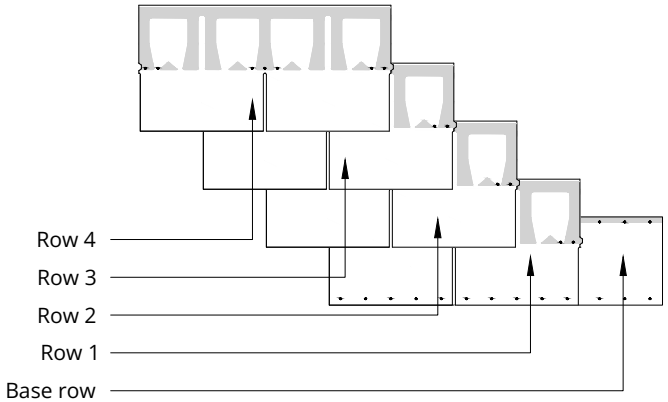
Bitumen roof sheet row arrangement for Round Cube 2.4 and 2.6

The base row is installed first, then the first row, etc. up in the middle of the sauna. The sheets that remain over the edge of the sauna wall are cut off and, if possible, used for other rows.

The base row starts at the front end of the sauna, row 1 always starts in the middle, the other rows are offset from the middle.

For row 1, use nails to fix the lower end, and for row 2, use the included bitumen silicone. Subsequent rows from the second row do not need fix from lower end.

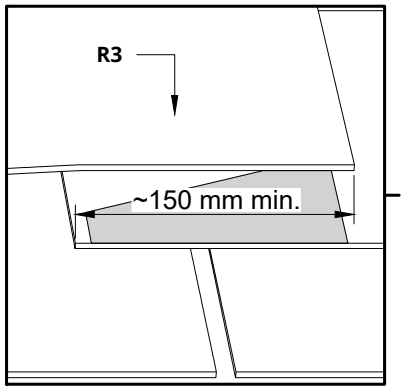
The layout pattern repeats every 4 rows.

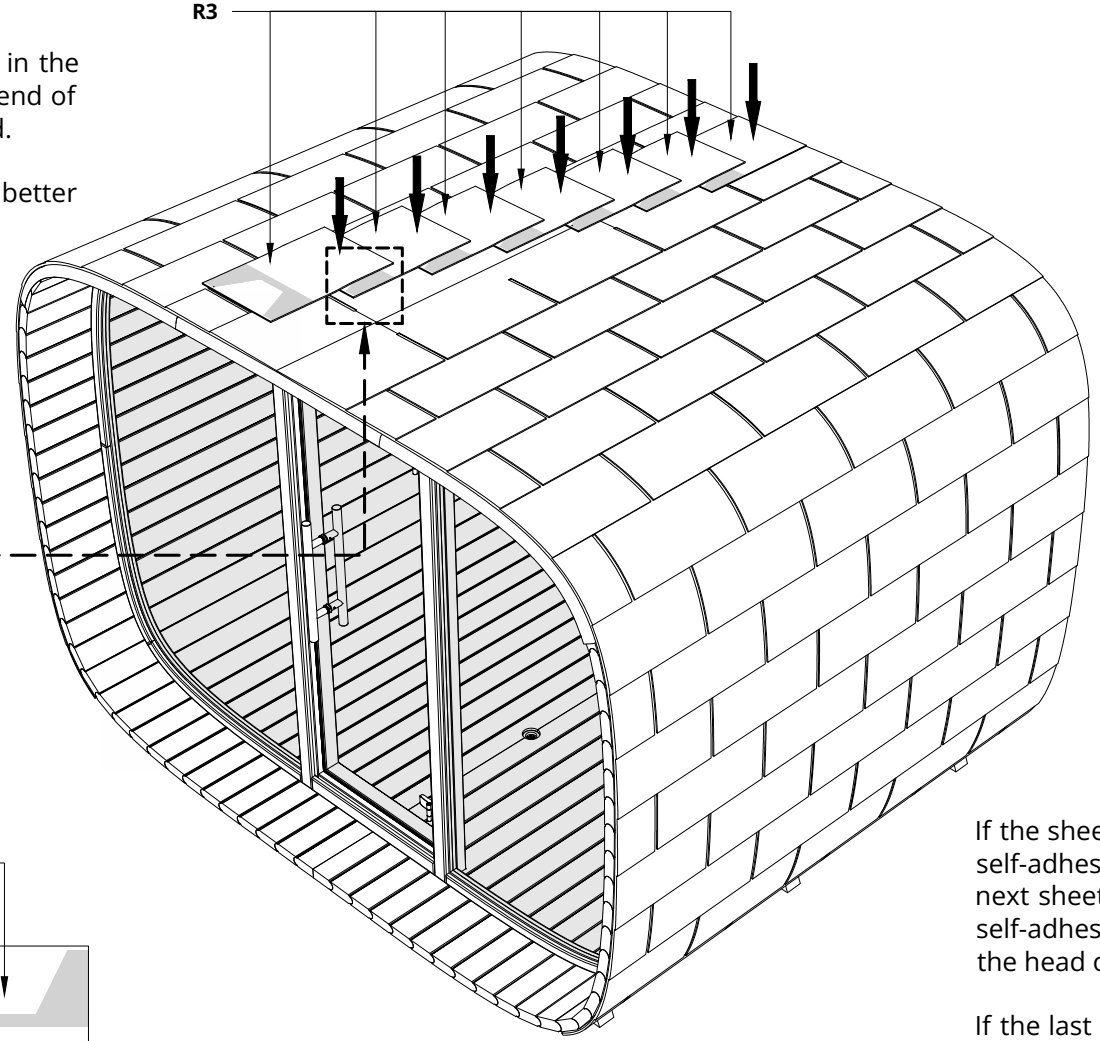


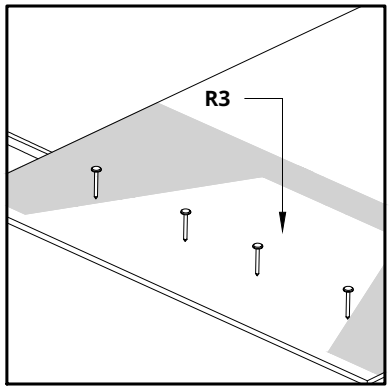
R5	Nail 2,5x25

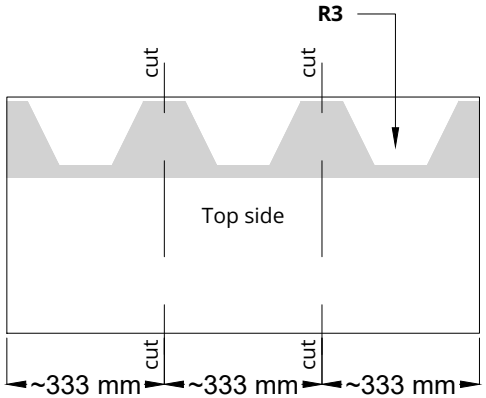
The roof ridge must be placed in the middle, starting from the back end of the sauna or from the front end.

Sheets are self-adhesive, for better adhesion use a heat source.









The first procedure is to cut the sheet into three pieces.

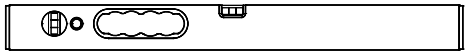
Remove the protective film from the sheet and put it in place by starting the ridge row from back end of the sauna or from the front end.

If the sheet is in place, fasten it with 4 nails on the self-adhesive spot as shown in the picture. The next sheet must be placed so that it overlaps the self-adhesive spot of the first sheet and covers the head of the nail min. length 150 mm.

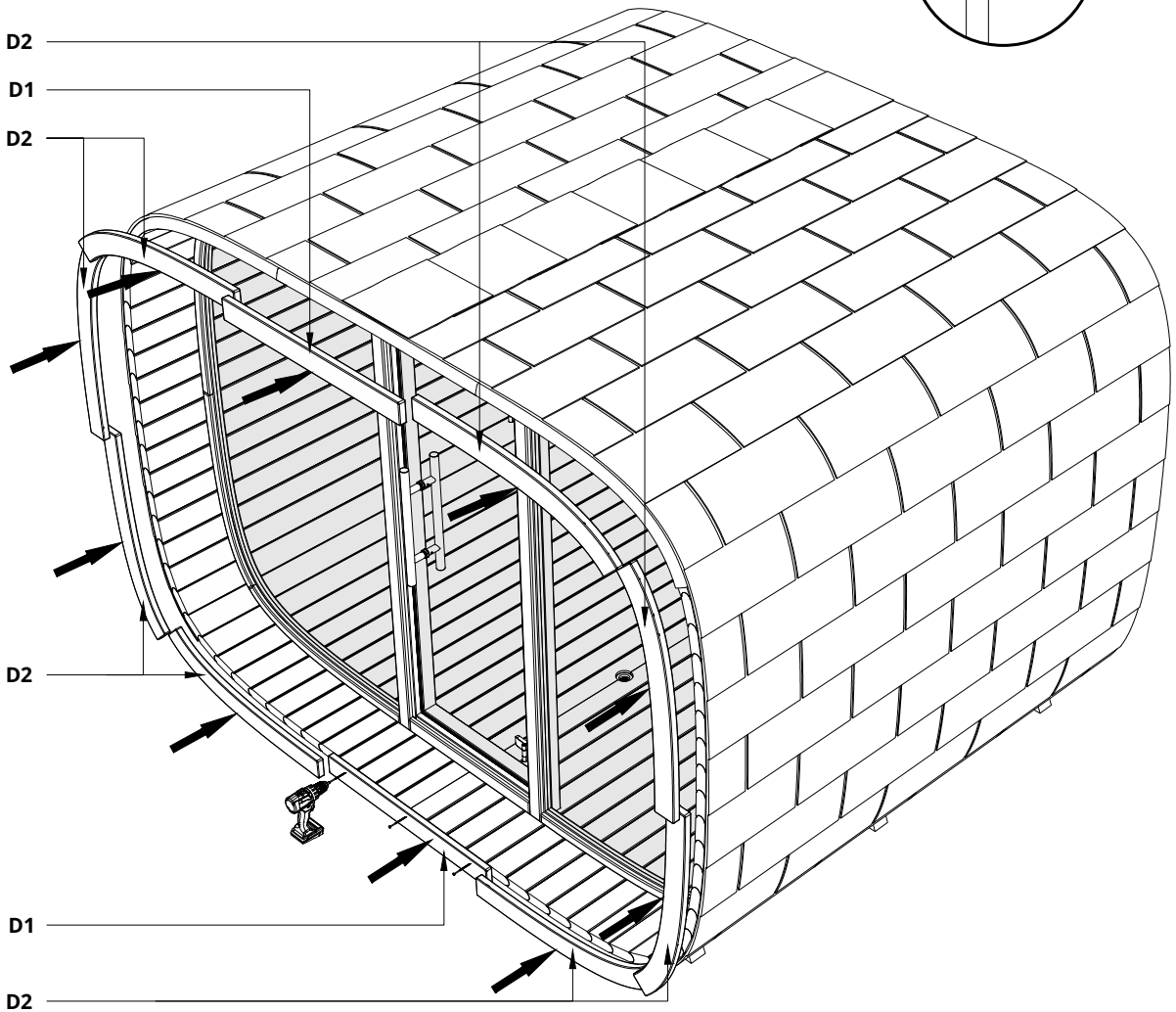
If the last sheet extends over the edge, it must be cut off, and if the self-adhesive part remains visible, it must be covered with a suitable piece of excess, use bitumen silicone for fixing.

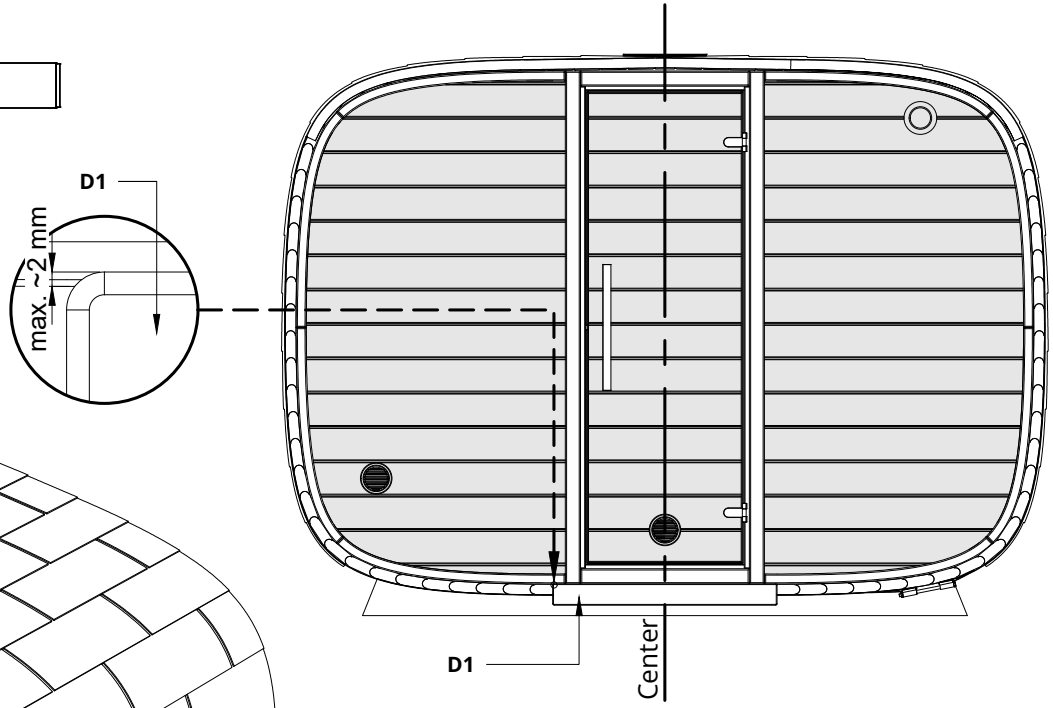
S6.1	Screws 4,5x70 (black coated)	x60

NB! use a level



Installation of cover boards at the front end and at the back end of the sauna.





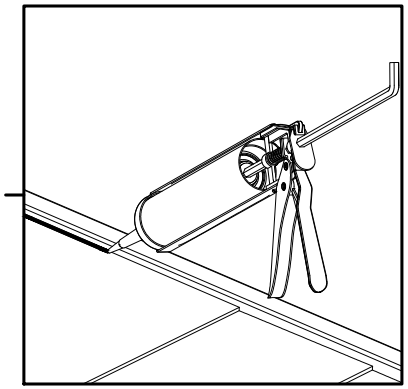
The installation of the cover boards is started from the bottom and the first cover board must be in the center at the front end and at the back end of the sauna.

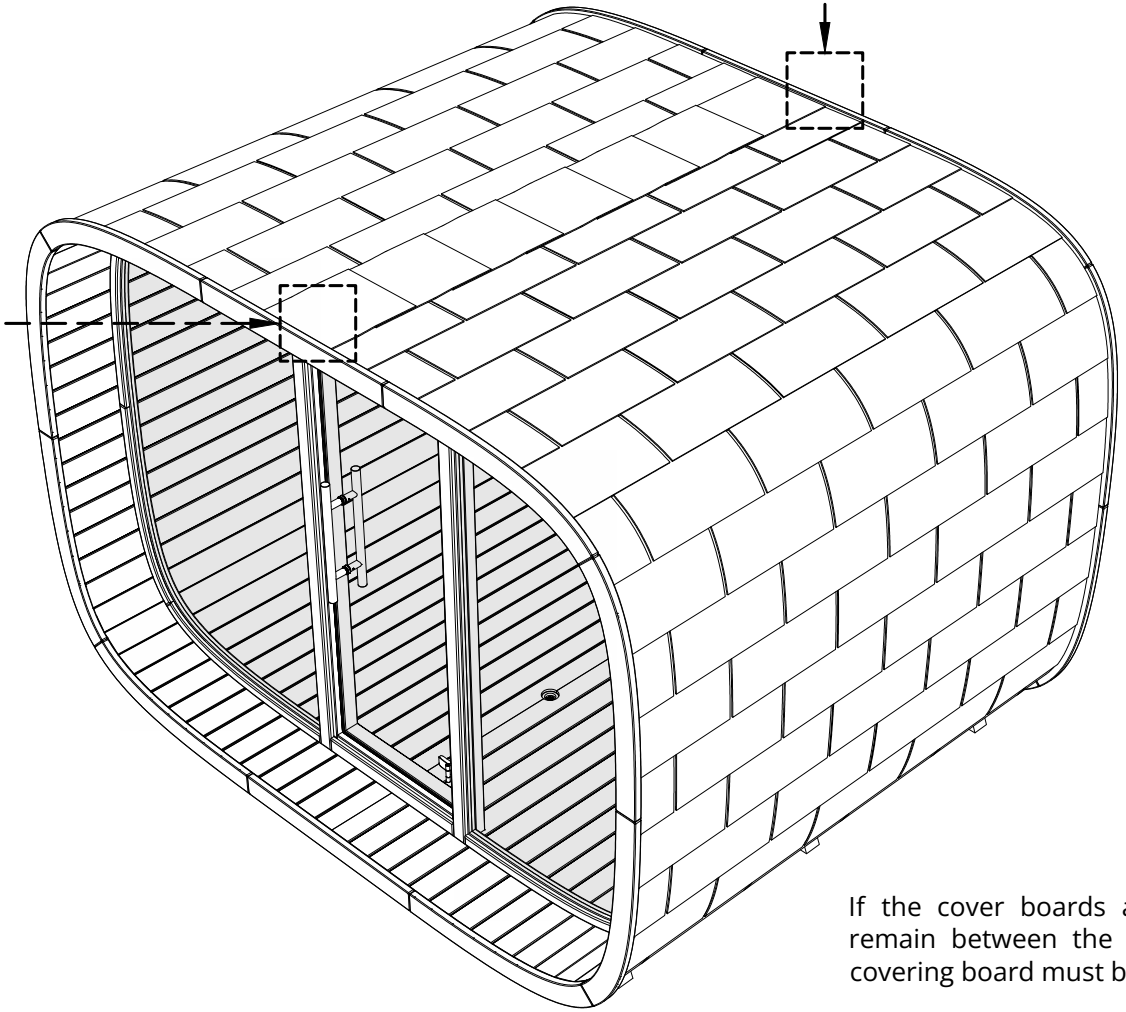
The upper edge of the first cover board must be at the same height as the floor. It can also be a little higher than the floor level, but not more than 2 mm.

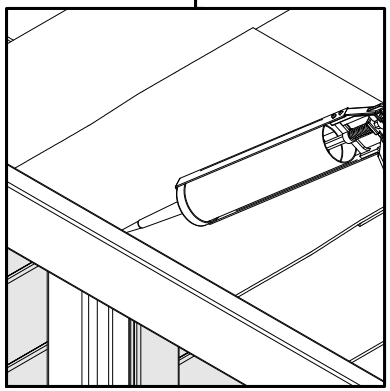
Glue must be added to the lower 3 cover boards before screwing. Each cover board is screwed with 3 screws.

If the front end of the sauna is done, the back end of the sauna must be done in the same way.

Please countersink the screw head!



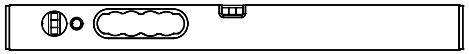




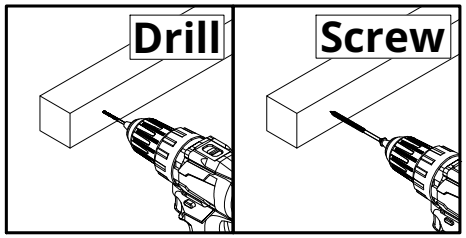
If the cover boards are in place, those gaps that remain between the roof bitumen sheets and the covering board must be filled with sealant.

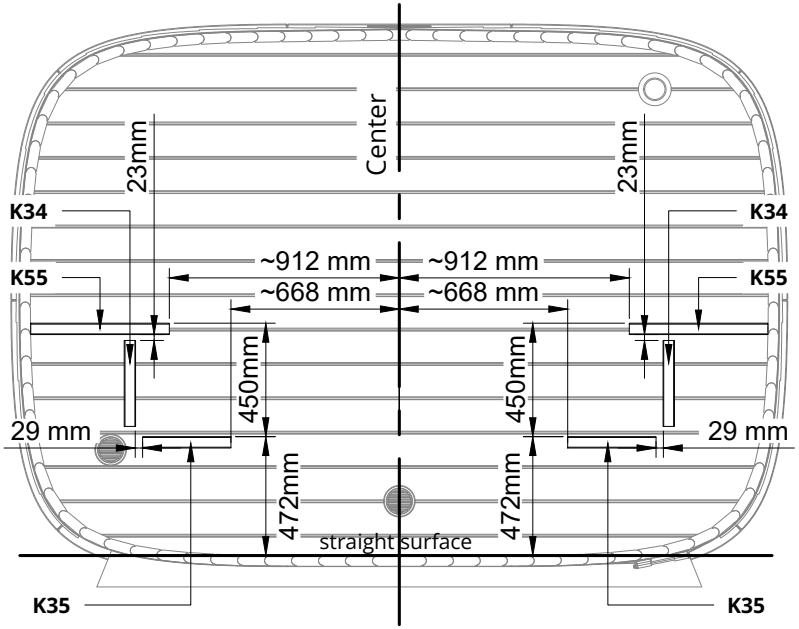
S7	Screws 4,5x80 for Spruce Screws 4,2x75 for Thermo	x16

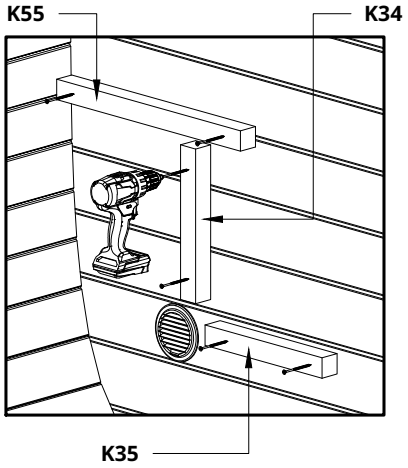
NB! use a level

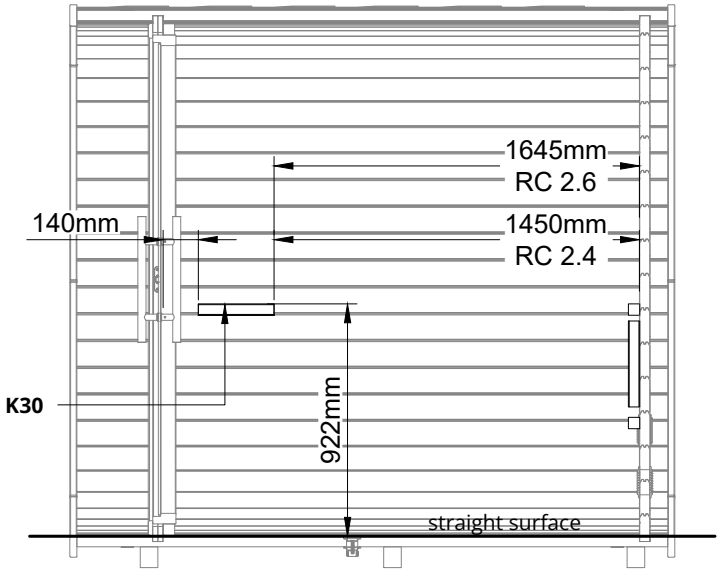


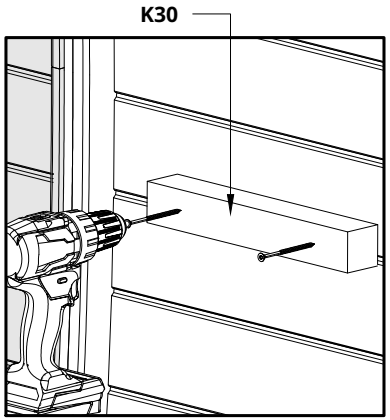
Notice!
Drill 4mm hole in the K.. square woods before screwing.











Height measurements are measured from a straight surface.

Please countersink the screw head!

First measure and install wall mount K35. Measure the height from straight surface and the distance from center. The upper edge height from the straight surface of K35 is shown in the picture.

Next measure and install K55. Measure the upper edge of the wall mount K55 from the wall mount K35 and the distance from center.

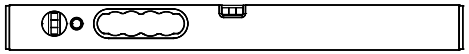
Next measure and install bench skirt wall mount K34. Measure the upper edge of the wall mount K34 and the outer edge depth distance from the wall mount K35. The K34 wall mount should be perpendicular to the K55 wall mount.

Now measure and install K30 on both sides. Measure the height straight surface and distance from the back wall.

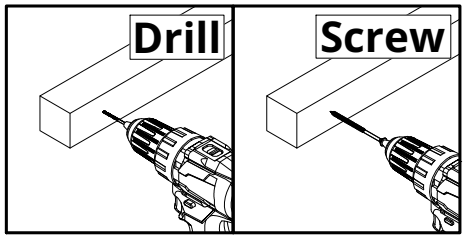
Before installing square wood K30, K34, K35 and K55, drill holes for screws. Add glue and then screw it to the wall and wipe off the excess glue.

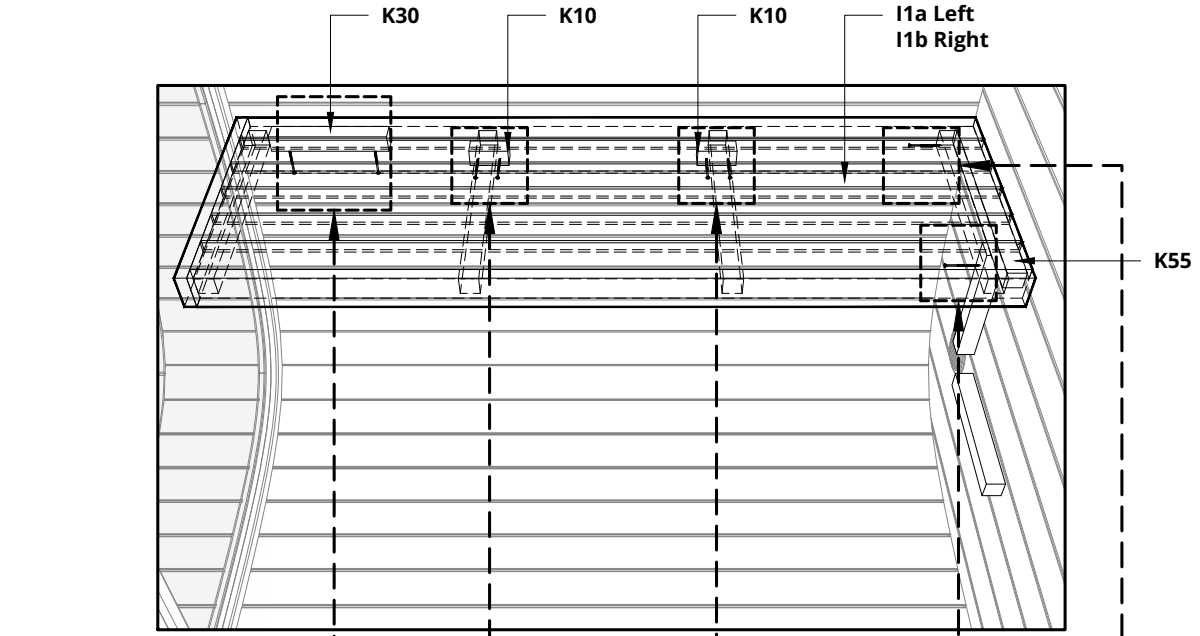
S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x4
S7	Screws 4,5x80 for Spruce Screws 4,2x75 for Thermo	x12

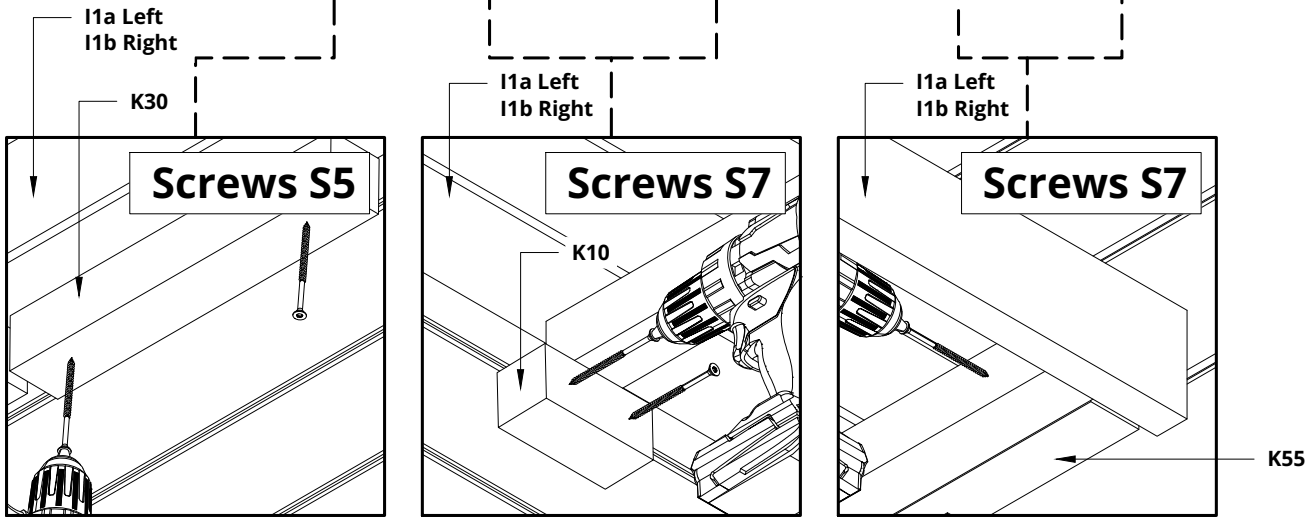
NB! use a level



Notice!
Drill 4mm hole in the K10 square wood before screwing.







Install and fix the I1a upper bench to the wall mounts K55 with two S7 screws and K30 with two S5 screws.

Install some aids to keep the bench level.

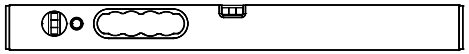
Once the upper bench is attached, K10 must be installed next. K10 must be installed at the lower edge of the square wood attached under the bench and fixed to the side wall with two S7 screws, the locations are shown in the pictures.

Before installing square wood K10, drill holes for screws. Add glue and then screw it to the wall and wipe off the excess glue.

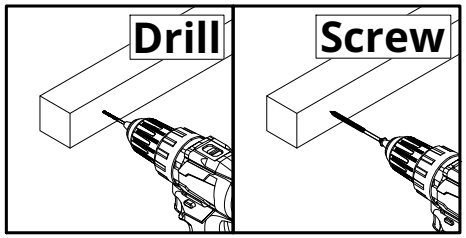
Repeat these steps on the other side as well!

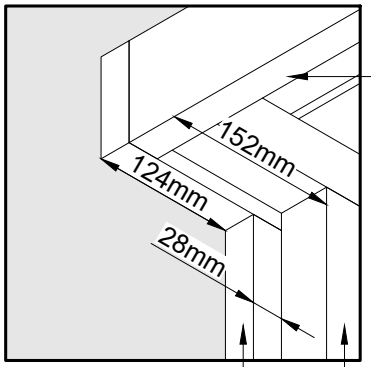
S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x8

NB! use a level



Notice!
Drill 4mm hole in the K.. square woods before screwing.





The measurement must be started from the lower edge of the square wood attached under the bench for square wood legs.
The square wood and cover board are longer, they must be cut to the correct size.
Please countersink the screw head!

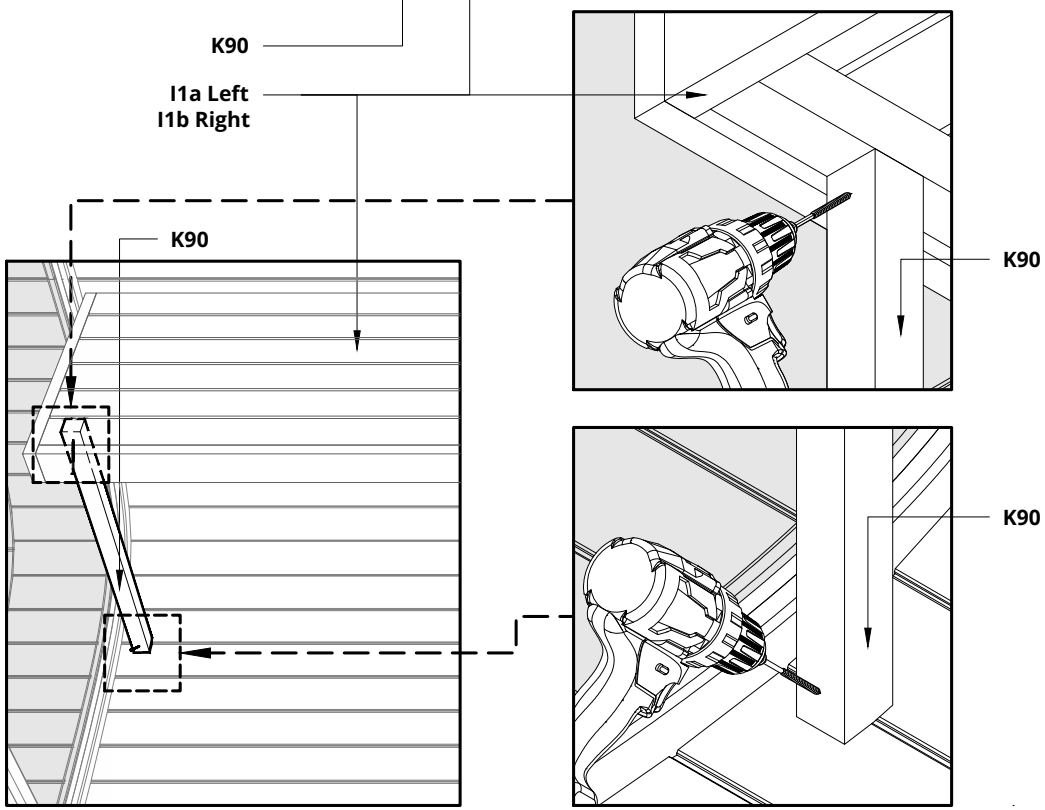
Before installation, mark the distance of the square wood K90 from the outer edge of the bench. Measure from bench I1a down to the floor. Cut the K90 to size. If it is cut correctly, make sure that square wood K90 stays perpendicular to the bench when attaching it.

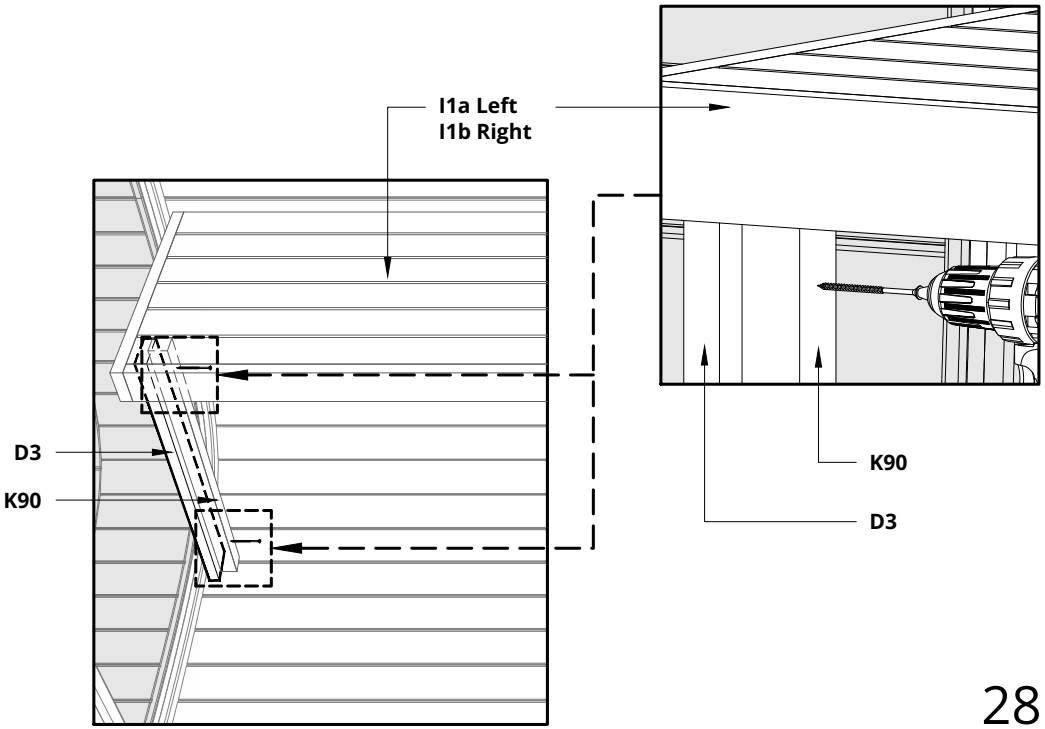
Before installing the cover board D3, mark the distance from the outer edge of the bench.

Measure from the marked point down to the floor. Cut the D3 cover board to size. If it is cut to size, fasten with two S5 screws.

Make sure that cover board D3 stays perpendicular to the bench and in parallel with K90 when attaching it to K90.

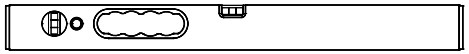
Repeat these steps on the other side as well!

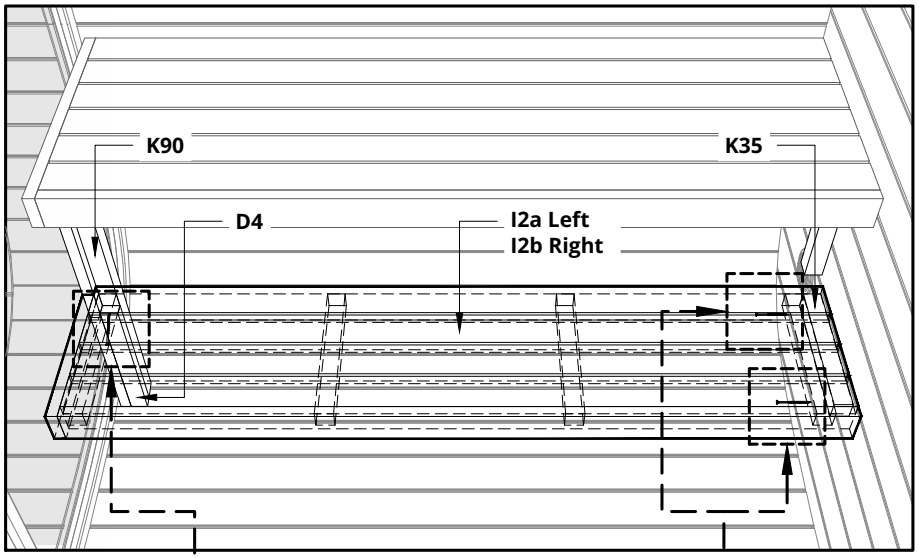


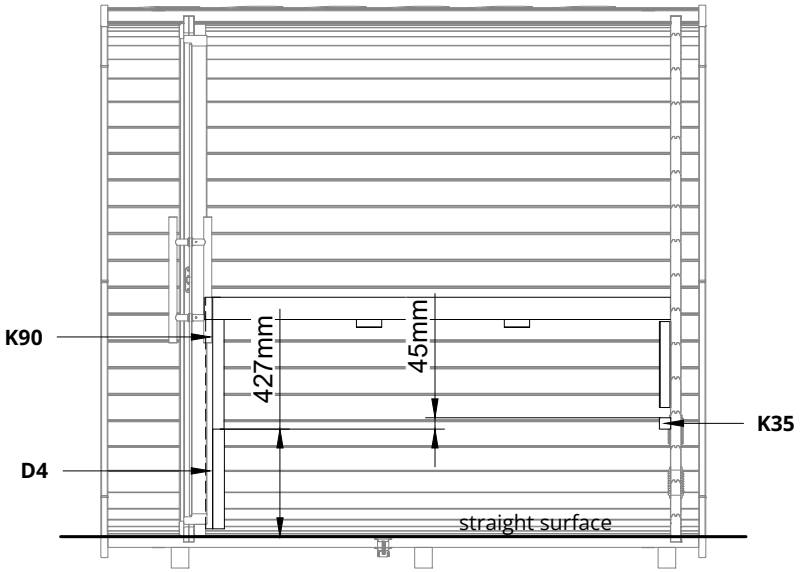


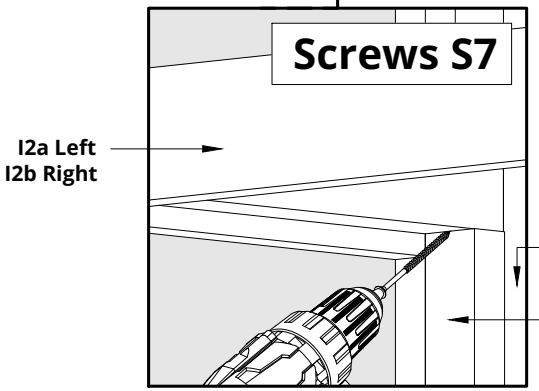
S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x4
S7	Screws 4,5x80 for Spruce Screws 4,2x75 for Thermo	x6

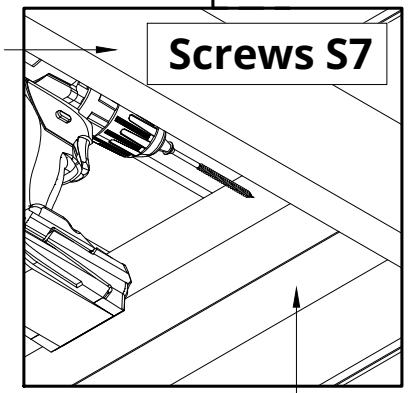
NB! use a level

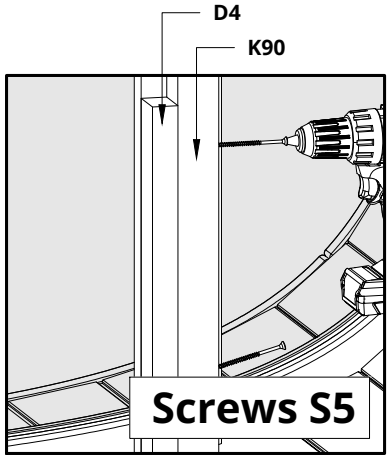












***The cover board is longer, it must be cut to the correct size*.**
Height measurements are measured from a straight surface.

First install cover board piece D4. Mark the upper edge of D4 cover board piece.

Measure from the marked point to the floor to get the measurement. Cut the D4 cover board piece to size.

Attach the D4 cover board piece to K90 square wood with two S5 screws.

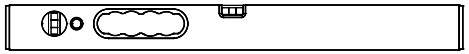
Now install and fix the I2a bench to the wall mounts K35 with two S7 screws and to K90 with one S7 screw.

Install an aid to keep the bench level.

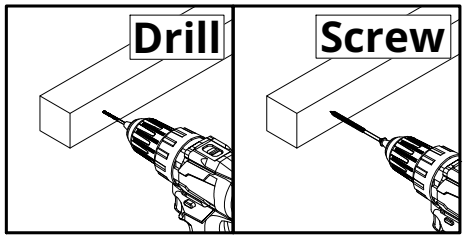
Repeat these steps on the other side as well!

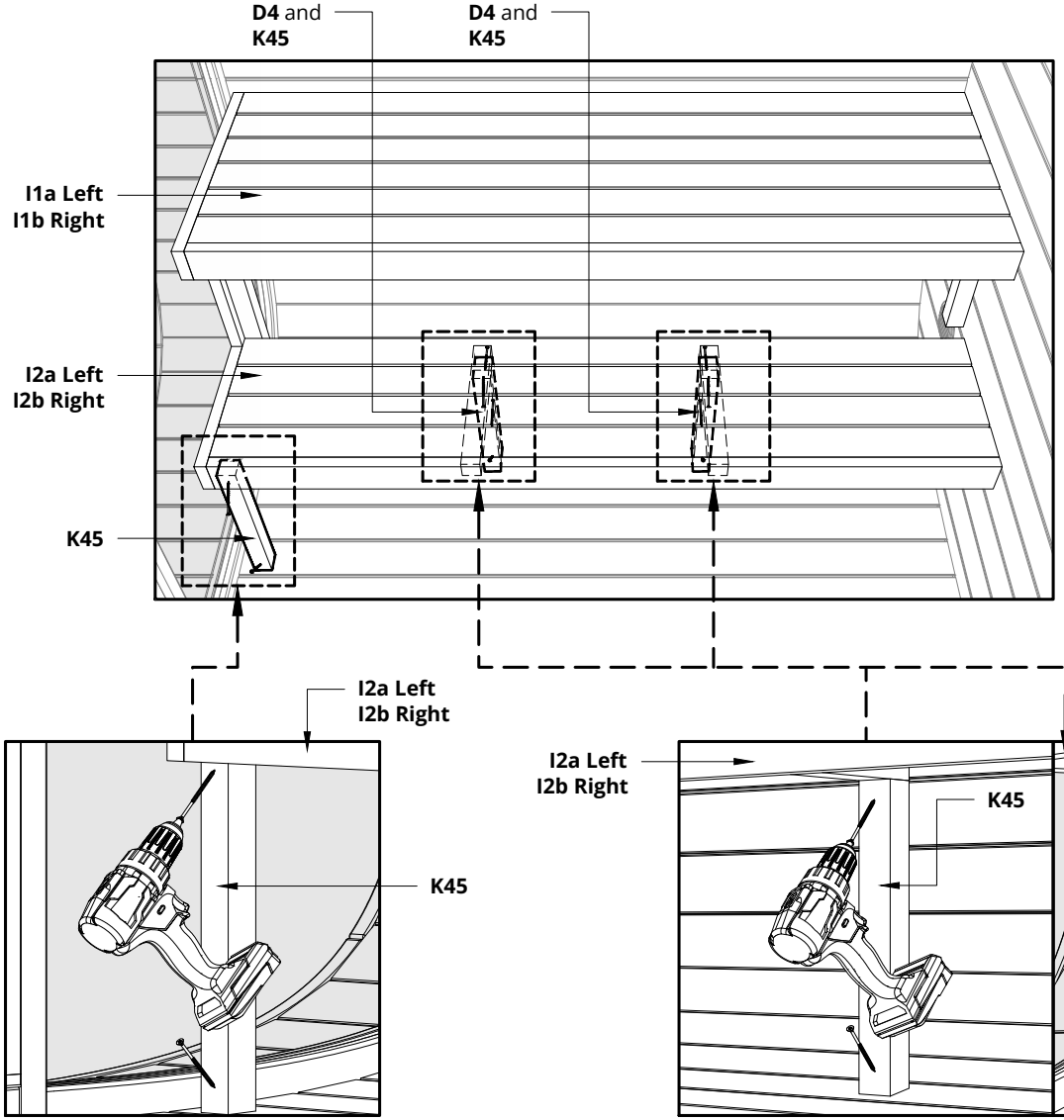
S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x20

NB! use a level



Notice!
Drill 4mm hole in the K.. square woods before screwing.





The measurement must be started from the lower edge of the square wood attached under the bench.
The square wood and cover board are longer, they must be cut to the correct size.

Please countersink the screw heads that are hidden behind the other part!

First measure and install the corner leg K45 of the middle bench I2a. Measure from the bench to the floor. Cut the K45 to size. If it is cut correctly, make sure that square wood K45 stays perpendicular to the bench when attaching it.

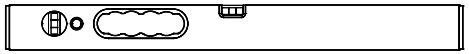
Next, install the two middle legs K45 of the middle bench I2a. Measure from the bench to the floor. Cut the K45 to size. If it is cut correctly, make sure that square wood K45 stays perpendicular to the bench when attaching it.

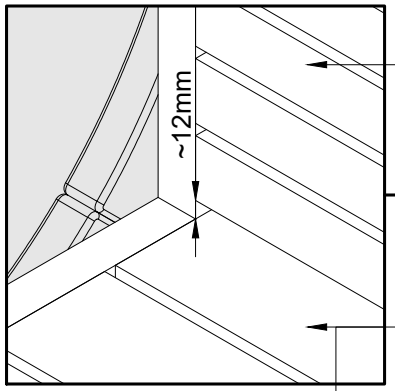
Now install cover boards D4 on the middle legs K45. Measure from the bench to the floor. Cut the D4 to size and install to the K45 legs with two screws each as shown in the picture.

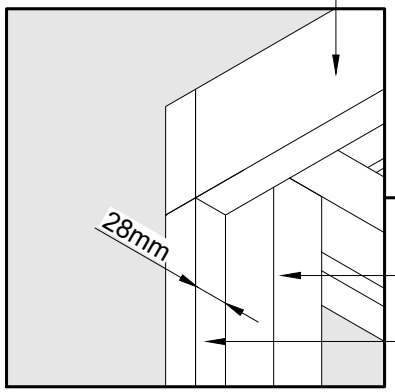
Repeat these steps on the other side as well!

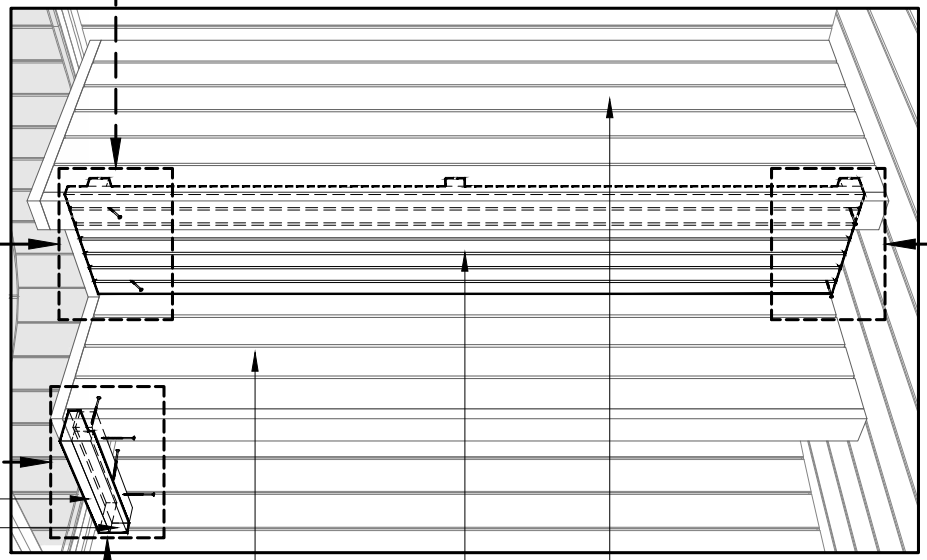
S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x16

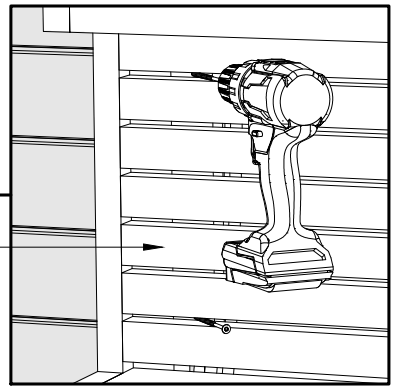
NB! use a level

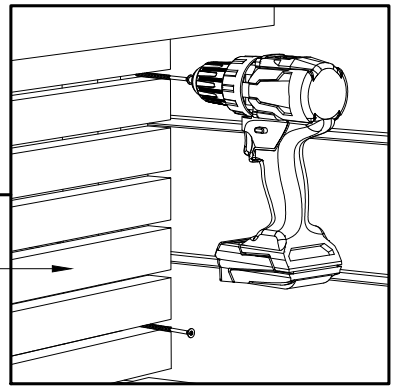


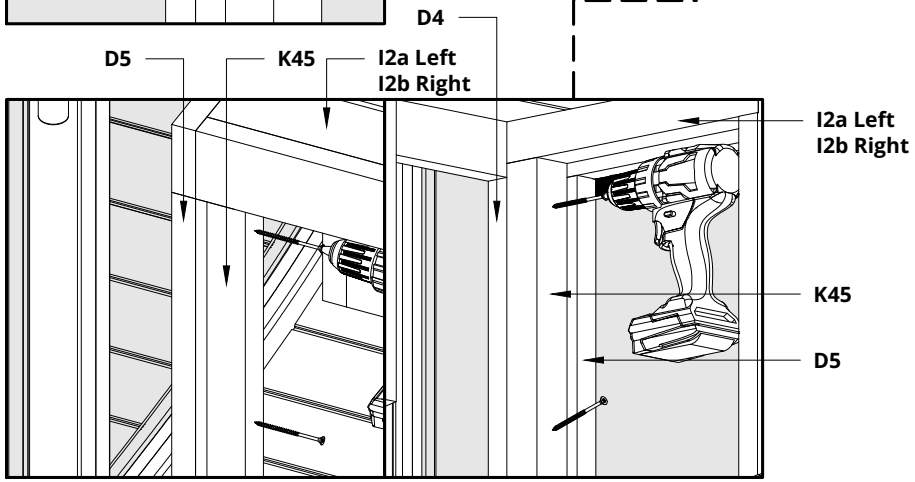












The cover board are longer, they must be cut to the correct size.

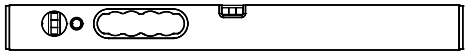
First measure and install the corner leg K45 cover boards D4 and D5. Measure from the bench to the floor. Cut the D4 and D5 to size. First install cover board D4 and then D5. Both are attached with two screws to the corner leg **K45 square wood**.

Next install the bench skirt I3. It must be placed so that there is a small gap between the lower edge and the middle bench I2a. Fasten with four screws.

Repeat these steps on the other side as well!

S2	Screws 3x40	x6
S5	Screws 4,5x60 for Spruce Screws 4,2x55 for Thermo	x6

NB! use a level

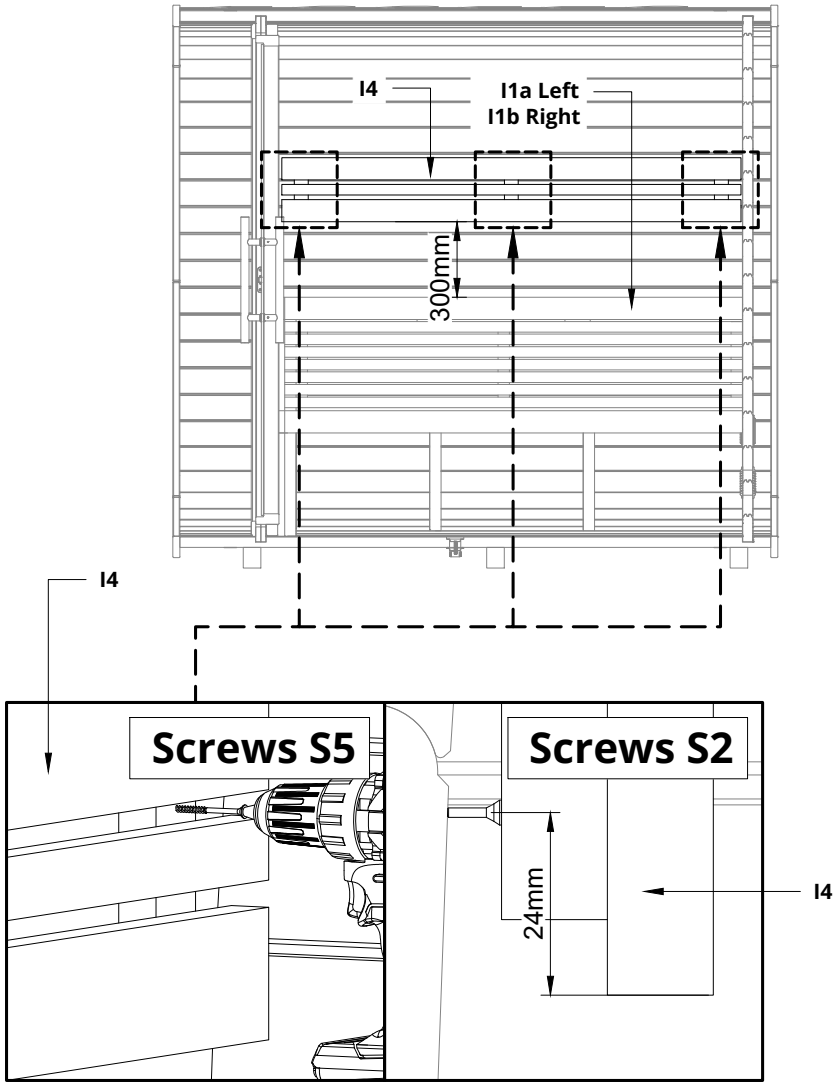


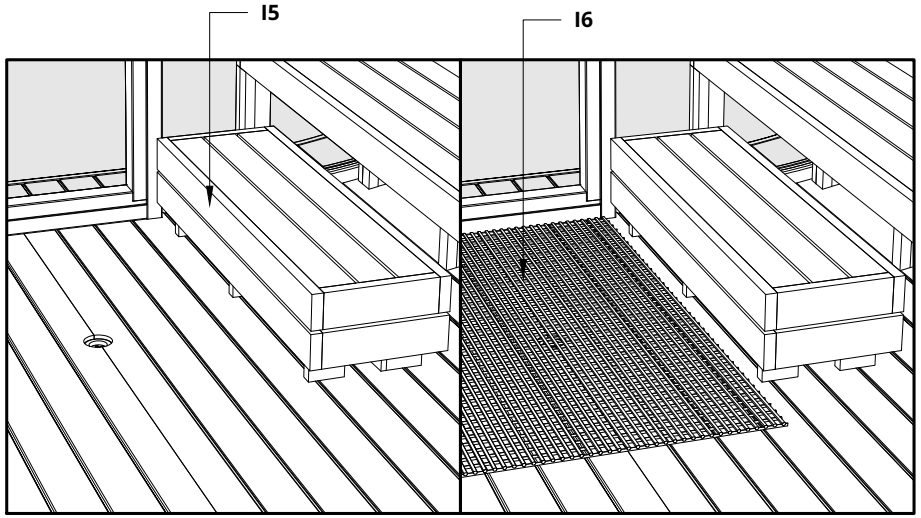
The height of the lower edge of the backrest is shown in the picture.

When you install the bench backrest I4. It needs to be set from the bottom edge as the wall is not flat. For leveling, use S2 screws, putting them behind the block with which the backrests are against the wall. At the beginning, screw the screws in, leaving 20 mm out, then, if necessary, turn them inward or outward. Or use spacer blocks.

Repeat these steps on the other side as bench backrest I4 well!

Next, place the step bench I5 on the left and also on the right, then place the floor mat.





IMPORTANT SAFETY INSTRUCTIONS

DANGER: Indicates a hazardous situation that, if not avoided, will result in death or serious injury.

WARNING: Indicates a hazardous situation that, if not avoided, could result in death or serious injury.

CAUTION: Indicates a hazardous situation that, if not avoided, could result in minor or moderate injury.

NOTICE: Indicates information considered important, but not hazard-related.

READ ALL INSTRUCTIONS BEFORE INSTALLATION AND USE TO AVOID INURY OR DAMAGE TO HEATER

FOLLOW SAFETY INFORMATION IN THIS DOCUMENT TO AVOID SERIOUS INJURY OR DEATH

REFER TO YOUR LOCAL BUILDING CODES FOR ANY SPECIFIC INSTALLATION REQUIREMENTS

ALL ELECTRICAL WORK NEEDS TO BE COMPLETED BY A LICENSED ELECTRICIAN. FAILURE TO DO SO COULD CAUSE INJURY OR DAMAGE TO THE HEATER.

MANUFACTURERS MANUAL TAKES PRECEDENCE OVER ANY DIRECTIONS LISTED IN THIS DOCUMENT

KEEP THESE INSTRUCTIONS FOR FUTURE REFERENCE

⚠ WARNING

• This appliance is not intended for use by persons (including children) with reduced physical, sensory or mental capabilities, or lack of experience and knowledge, unless they have been given supervision or instruction concerning use of the appliance by a person responsible for their safety.

• Consult your doctor about any health-related limitations related to sauna use. Ignoring advice from your medical provider could cause serious injury or death.

• Do not let people with pre-existing health conditions bathe in the sauna on their own. Using the sauna could cause these users to lose consciousness.

• Parents should consult your pediatrician before allowing children to use the sauna. Ignoring advice from your medical provider could cause serious injury or death.

• Do not smoke, use alcohol, or exercise in the sauna. These tasks could cause users to lose consciousness.

• Do not exceed 30 min. in the sauna at one time, as excessive exposure may be harmful to health. The sauna should not be used as an endurance test.

• Do not place any combustible material over the sauna heater (towels, bathing suits, wooden bucket or ladle)! This will cause the sauna to catch fire.

• Hyperthermia occurs when the internal temperature of the body reaches a level several degrees above the normal body temperature of 98,6 °F. The symptoms of hyperthermia include an increase in the internal temperature of the body, dizziness, lethargy, drowsiness, and fainting.

• Do not sleep in a sauna in which the heater is operating. Sleeping in a heated sauna may lead to injury or death.

• Do not alter the heater in any way, unless explicitly instructed in this manual. Altering the heater could cause electrocution or fire risk.

• Only use stones approved for sauna heater use. Inadequate stones may crack or explode leading to serious injury.

⚠ CAUTION

• Keep all occupants away from the heater and when it is hot. The stones and outer surface of the heater may burn your skin.

• Do not throw excessive amounts of water on the stones. The evaporating water is boiling hot and could cause burns.

• Do not throw water directly onto the elements. This could cause burns and damage to the heater.

• Be very careful when moving in the sauna, as the benches and floors may be slippery. This could cause the user to slip and fall.